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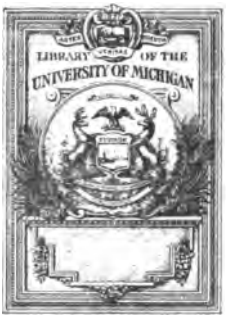
USEFUL INFORMATION CONCERNING BOOK IMPOSITIONS



PRESENTED BY
THE PUBLISHER

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1920

"Why the Present High Cost in Bookbinding."

Published by

J. F. TAPLEY COMPANY

May, 1920.

Copies may be obtained, gratis, by writing the publishers.

Useful Information

CONCERNING

BOOK IMPOSITIONS

Including all the modern and many special layouts hitherto not generally known

SECOND EDITION

REVISED AND
ENLARGED

COMPILED AND PUBLISHED BY
J. F. TAPLEY CO.
Book Manufacturers
NEW YORK

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J. F. Tapley Company

Received 2-12-20 ELW

INTRODUCTION

To the Second Edition

The first edition of this little book on Impositions, issued in 1914, was exhausted in less than six months. Since that time we have reprinted from time to time the most generally used layouts that printers and publishers might be kept supplied.

It was our intention to have ready for the press before this, a complete volume on book-making which would treat in detail the technical and trade names of the various operations in binding and include an entirely new and up-to-date section on Impositions. The Great War, coupled with the difficulties of securing materials, expert employees and in general the hardship of operating a large book manufacturing business under post-war conditions has delayed this volume which will be issued in 1921.

Consequently, the urgent demand for a more complete collection of all the modern layouts has caused us to issue, in similar form to the first edition, this revised form of "Book Impositions."

It is hoped that it will meet the requirements of the trade in general and prove as useful a text book as the original edition.

J. F. TAPLEY COMPANY.

November, 1920.

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GENERAL INFORMATION

To select the imposition best suited to a publication invariably rests with the binder, dependent, of course, upon the imposing equipment of the printer.

Obviously it is desirable to use at all times an imposition which shall permit the folding of as many signatures from the full sheet at one operation as the size and weight of paper will permit.

To begin with we must first ascertain the size of the full sheet to be printed, knowing this, determine the number of pages to be put into each signature; four, eight, twelve,* sixteen, twenty,* twenty-four,* thirty-two, or sixty-four.

It is clearly understood that weight of paper governs the number of pages in a signature. Bible papers work best in units of 32 pages, may also be worked in double thirty-two's inserted; light weight coateds, supers, machine finishes and antiques may also be attempted in 32's, provided perforating devices are available on the folders. Medium and heavy weight coateds, supers, machine finishes and antiques must be limited to eight or sixteen-page signatures. Books consisting of but sixteen, thirty-two or sixty-four pages, may, if heavy papers are used, or added appearance of bulk is desired, be imposed as eight-page signatures.

*Indicates unusual signatures.

The following tables may be taken as a guide for all ordinary work. As nearly every contract has some peculiarity, either of paper, pagination, margins or layout, it is always wise to have a proof of first form approved by the binder while making ready on the original run.

Starting with the proper imposition, careful attention should be paid to the placing of round or slit points, guide edges, indicators and cutting of sheets on press if such is to be done.

The grain of all papers should run parallel to the backbone of the book. All papers should be squared before printing if guide edges are to be used in folding.

Drop roll, double or single point sheets should have round point holes perforated through the sheet—two sets between heads on double point and drop roll sheets, and one set on single point sheets, placed 15 inches apart, centered between heads.

Quadruple sheets should have two sets of automatic point slits, clearly and sharply perforated, not less than 6 inches nor more than 8 inches away from edge of sheet.

It is the custom for printers to deliver all sheets uniformly jogged up to binders ready for hand or automatic feeding. Sheets not jogged up, broken or transposed guide edges, omitted or mixed point holes, point holes or slits not punched through, necessitate extra labor not estimated upon and carry an extra charge to the printer or publisher.

Use care and the results will be uniformly satisfactory.

The following impositions are intended as a guide to printers when printing all of the modern layouts and represent the various methods of folding ordinarily used; special folds, peculiar arrangements incident to loose leaf and other bindings can only be determined by analysis of such propositions. Consult the Binder.

IMPOSITION TABLE OF SIZES

Machine	Folds and Delivers	Smallest Sheet	Largest Sheet	Folded Signatures		Impositions on Pages
				Smallest	Largest	
One Fold Rapid	One Four	6 x 8	10 x 14	4 x 6	7 x 10	11–12
One Fold Chopper	One Four	7 x 8	25 x 26	3½ x 8	13 x 25	11–12
Two Fold Jobber	One Eight	14 x 19	36 x 48	7 x 9½	18 x 24	13–14
Three Fold Jobber	One Sixteen	14 x 19	36 x 48	4¾ x 7	12 x 18	15–16
Four Fold Jobber	One Twenty-four	14 x 14½	36 x 36	4¾ x 7	9 x 12	17–18
Four Fold Jobber	One Thirty-two	14 x 19	36 x 48	3½ x 4¾	9 x 12	19–20
Two up Jobber	2-16's, one above other	14 x 19	36 x 48	4¾ x 7 *4¾ x 14	9 x 12 *9 x 24	21–22
Two up Jobber	2-32's, one above other	14 x 19	36 x 48	2⅜ x 3½ *2⅜ x 7	6 x 9 *6 x 18	23–24
Four up Jobber	4-32's, one above other	20 x 30	36 x 48	2½ x 3¾ *5 x 15	4½ x 6 *9 x 24	25–26
Single Point	Single 16	12½ x 14	24 x 36	3½ x 6¼	9 x 12	27–28
Double Point	Two single 16's	14 x 25	31 x 44	3¼ x 6¼	7¾ x 11	29–30
Double Point Insert	Two Inserted 16's	14 x 25	31 x 44	3½ x 6¼	7¾ x 11	31–32
Drop Roll Double 16	Two Single 16's	20 x 28	40 x 56	4¾ x 6½	10 x 14	33–34
Drop Roll Double 16 Inserted	Two Inserted 16's	20 x 28	40 x 56	4¾ x 6½	10 x 14	35–36

*Two sizes given indicate the size of the single also the two or more up folded section.

IMPOSITION TABLE OF SIZES (*Continued*)

Machine	Folds and Delivers	Smallest Sheet	Largest Sheet	Folded Signatures		Imposi-tions on Pages
				Smallest	Largest	
Drop Roll Double 32 Dexter and Chambers	Two Single 32's	20 x 28	40 x 56	3¼ x 4¾	7 x 10	37–38
Drop Roll Double 32 Inserted, Chambers	Two 32's Inserted as one 64	20 x 28	40 x 54	3¼ x 4¾	6¾ x 10	39–40
Drop Roll Double 32 Inserted, Dexter	Two 32's Inserted as one 64	20 x 30	40 x 56	3¾ x 5	7 x 10	41–42
Two Up Double 32 Drop Roll Dexter	Two pair of 32's, One Above Other	20 x 30	40 x 56	2½ x 3½ **5 x 7*	3½ x 5 **7 x 10*	43–44
Two Up Double 64 Drop Roll Dexter	Two pair of 64's, One Above Other	32 x 43	40 x 56	2½ x 4 **5 x 8*	3½ x 5 **7 x 10*	45–46
Quadruple Small	Four 16's	28 x 36	36 x 52	4½ x 7	6½ x 9	47–48
Quadruple Large	Four 16's	30 x 38	38 x 54	4¾ x 7½	6¾ x 9½	47–48
Quadruple Small Oblong	Two 16's	28 x 36	36 x 52	9 x 7 Oblong	13 x 9 Oblong	49–50
Quadruple Large Oblong	Two 16's	30 x 38	38 x 54	9½ x 7½ Oblong	13½ x 9½ Oblong	49–50
Quadruple Small, 4 on Two Up	Four Pair of 16's, Two up	28 x 36	36 x 52	3½ x 4½ *7 x 9	4½ x 6½ *9 x 13	51–52
Quadruple Large, 4 on Two Up	Four Pair of 16's, Two Up	30 x 38	38 x 54	3¾ x 4¾ *7½ x 9½	4¾ x 6¾ *9½ x 13½	51–52
Quadruple Inserting { Dexter Chambers	Four 16's, Inserted as Two 32's	25 x 33 20 x 30	40 x 56 40 x 54	4⅛ x 6¼ 3¾ x 5	7 x 10 6¾ x 10	53–54

*Two sizes given indicate the size of the single also the two or more up folded section.

**Folded on single-fold machine afterwards to give 2½ x 7 minimum to 3½ x 10 maximum.

IMPOSITION TABLE OF SIZES

Machine	Folds and Delivers	Smallest Sheet	Largest Sheet	Folded Signatures		Impositions on Pages
				Smallest	Largest	
One Fold Rapid	One Four	6 x 8	10 x 14	4 x 6	7 x 10	11–12
One Fold Chopper	One Four	7 x 8	25 x 26	3½ x 8	13 x 25	11–12
Two Fold Jobber	One Eight	14 x 19	36 x 48	7 x 9½	18 x 24	13–14
Three Fold Jobber	One Sixteen	14 x 19	36 x 48	4¾ x 7	12 x 18	15–16
Four Fold Jobber	One Twenty-four	14 x 14½	36 x 36	4¾ x 7	9 x 12	17–18
Four Fold Jobber	One Thirty-two	14 x 19	36 x 48	3½ x 4¾	9 x 12	19–20
Two up Jobber	2-16's, one above other	14 x 19	36 x 48	4¾ x 7 *4¾ x 14	9 x 12 *9 x 24	21–22
Two up Jobber	2-32's, one above other	14 x 19	36 x 48	2⅜ x 3½ *2⅜ x 7	6 x 9 *6 x 18	23–24
Four up Jobber	4-32's, one above other	20 x 30	36 x 48	2½ x 3¾ *5 x 15	4½ x 6 *9 x 24	25–26
Single Point	Single 16	12½ x 14	24 x 36	3½ x 6¼	9 x 12	27–28
Double Point	Two single 16's	14 x 25	31 x 44	3¼ x 6¼	7¾ x 11	29–30
Double Point Insert	Two Inserted 16's	14 x 25	31 x 44	3½ x 6¼	7¾ x 11	31–32
Drop Roll Double 16	Two Single 16's	20 x 28	40 x 56	4¾ x 6½	10 x 14	33–34
Drop Roll Double 16 Inserted	Two Inserted 16's	20 x 28	40 x 56	4¾ x 6½	10 x 14	35–36

*Two sizes given indicate the size of the single also the two or more up folded section.

IMPOSITION TABLE OF SIZES (*Continued*)

Machine	Folds and Delivers	Smallest Sheet	Largest Sheet	Folded Signatures		Imposi-tions on Pages
				Smallest	Largest	
Drop Roll Double 32 Dexter and Chambers	Two Single 32's	20 x 28	40 x 56	3¼ x 4¾	7 x 10	37–38
Drop Roll Double 32 Inserted, Chambers	Two 32's Inserted as one 64	20 x 28	40 x 54	3¼ x 4¾	6¾ x 10	39–40
Drop Roll Double 32 Inserted, Dexter	Two 32's Inserted as one 64	20 x 30	40 x 56	3¾ x 5	7 x 10	41–42
Two Up Double 32 Drop Roll Dexter	Two pair of 32's, One Above Other	20 x 30	40 x 56	2½ x 3½ **5 x 7*	3½ x 5 **7 x 10*	43–44
Two Up Double 64 Drop Roll Dexter	Two pair of 64's, One Above Other	32 x 43	40 x 56	2½ x 4 **5 x 8*	3½ x 5 **7 x 10*	45–46
Quadruple Small	Four 16's	28 x 36	36 x 52	4½ x 7	6½ x 9	47–48
Quadruple Large	Four 16's	30 x 38	38 x 54	4¾ x 7½	6¾ x 9½	47–48
Quadruple Small Oblong	Two 16's	28 x 36	36 x 52	9 x 7 Oblong	13 x 9 Oblong	49–50
Quadruple Large Oblong	Two 16's	30 x 38	38 x 54	9½ x 7½ Oblong	13½ x 9½ Oblong	49–50
Quadruple Small, 4 on Two Up	Four Pair of 16's, Two up	28 x 36	36 x 52	3½ x 4½ *7 x 9	4½ x 6½ *9 x 13	51–52
Quadruple Large, 4 on Two Up	Four Pair of 16's, Two Up	30 x 38	38 x 54	3¾ x 4¾ *7½ x 9½	4¾ x 6¾ *9½ x 13½	51–52
Quadruple Inserting { Dexter Chambers	Four 16's, Inserted as Two 32's	25 x 33 20 x 30	40 x 56 40 x 54	4⅛ x 6¼ 3¾ x 5	7 x 10 6¾ x 10	53–54

*Two sizes given indicate the size of the single also the two or more up folded section.

**Folded on single-fold machine afterwards to give 2½ x 7 minimum to 3½ x 10 maximum.

IMPOSITION SCALE OF WEIGHTS

Based on Papers 25x38 Basis to Show Proper Imposition

Weight on 25x38 Basis	Should be Worked in Signatures of	Folded Sheet			Full Flat Sheet		Signatures to Sheet	Imposition	Imposition on Pages
			Smallest	Largest	Smallest	Largest			
20 lb. India Bible.....	32 pages.	Single	3½x 4¾	9x12	14x19	36x48	One	Jobber 4 fold.....	19–20
		Double	3¾x 4¾	7x10	20x28	40x56	Two	Double 32 drop roll..	
20 lb. India Bible.....	Can be done in 64 pages		3¼x 4¾	6¾x10	20x28	40x56	Two Inserted 32's	Chambers — Drop roll	39–40
			3¾x 5	7x10	20x30	40x56		Dexter — double 32 insert	41–42
30 lb. M. F. Ctd, Ant.etc.	32 pages.	Single	3½x 4¾	9x12	14x19	36x48	One	Jobber 4 fold.....	19–20
		Double*	3¼x 4¾	7x10	20x28	40x56	Two	Drop roll D 32.....	37–38
40 lb.....	32 pages.	Single	3½x 4¾	9x12	14x19	36x48	One	Jobber 4 fold.....	19–20
		Double*	3¼x 4¾	7x10	20x28	40x56	Two	Drop roll D 32.....	37–38
50 lb.....	32 pages.	Single	3½x 4¾	9x12	14x19	36x48	One	Jobber 4 fold.....	19–20
		Double*	3¼x 4¾	7x10	20x28	40x56	Two	Drop roll D 32.....	37–38
60 lb.....	16 pages.	Single	4¾x19	12x18	14x19	36x48	One	Jobber 3 fold.....	15–16
		Double*	4¾x 6½	10x14	20x28	40x56	Two	Drop roll D 16.....	33–34
		Quadruple	4½x 7	6¾x9½	28x36	38x54	Four	Quadruple.....	47–48
70 lb.....	16 pages.	Single	4¾x19	12x18	14x19	36x48	One	Jobber 3 fold.....	15–16
		Double*	4¾x 6½	10x14	20x28	40x56	Two	Drop roll D 16.....	33–34
		Quadruple	4½x 7	6¾x9½	28x36	38x54	Four	Quadruple.....	47–48
80 lb.....	16 pages.	Single	4¾x19	12x18	14x19	36x46	One	Jobber 3 fold.....	15–16
		Double	4¾x 6½	10x14	20x28	40x56	Two	Drop Roll D 16.....	33–34
		Quadruple	4½x 7	6¾x9½	28x36	38x54	Four	Quadruple.....	47–48
90 to 130 lb..	16 pages.	Single	4¾x 7	12x18	14x19	36x48	One	Jobber 3 fold.....	15–16
		Double	4¾x 6½	10x14	20x28	40x56	Two	Drop roll D 16.....	33–34
140 lb. and over.....	8 pages..		7½x 9½	18x24	14x19	36x48	One	Jobber 2 fold or (hand).....	13–14
	16 pages..		4¾x 7	12x18	14x19	36x48	One		15–16

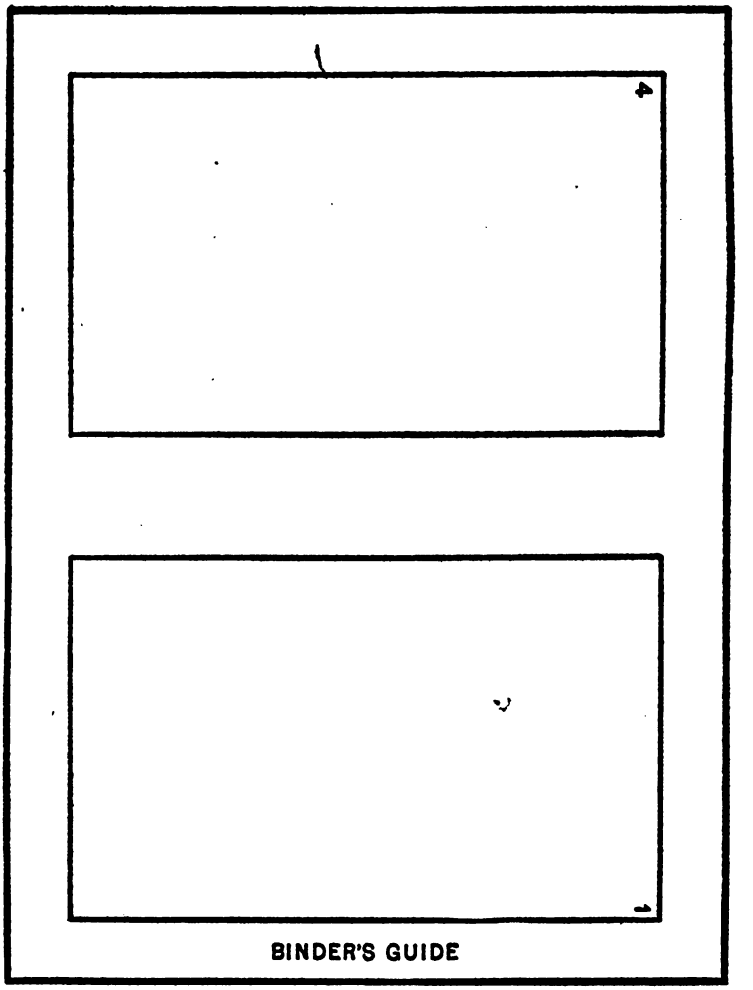
(See pages 6-7 for special rules governing oblong-quadruple, two and four up sixteen, thirty-two, sixty-four page signatures.)

*All of these weights may be worked in quadruple sixteens inserted to give two thirty-two page sections. See range of sizes on pages 8-9 and Impositions on pages 53-54.

FOUR PAGES HAND FOLD

(Also Single Fold Machine)

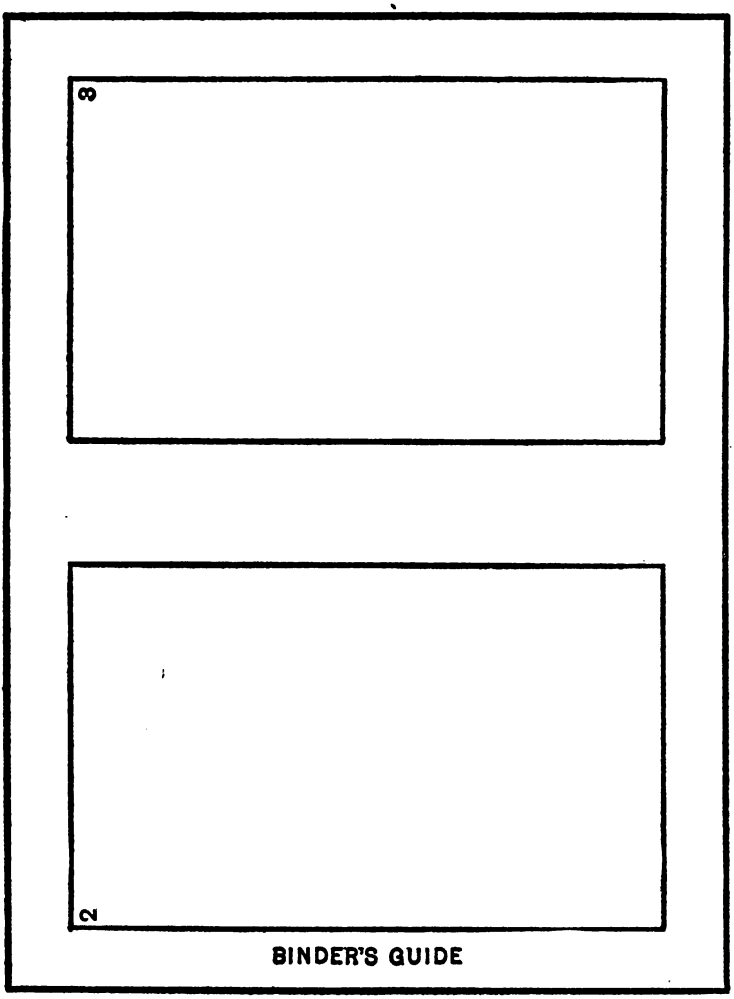
SINGLE FOLD OUTSIDE FORM



FOUR PAGES HAND FOLD

(Also Single Fold Machine)

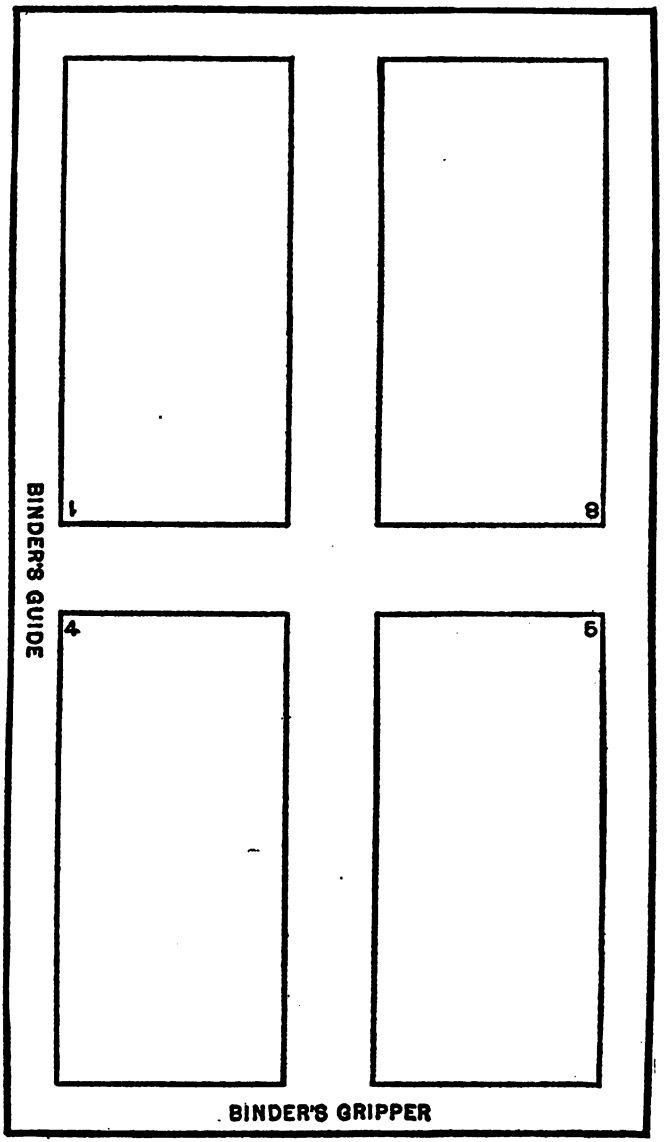
SINGLE FOLD INSIDE FORM



EIGHT PAGES HAND FOLD

(Also Jobber Machine)

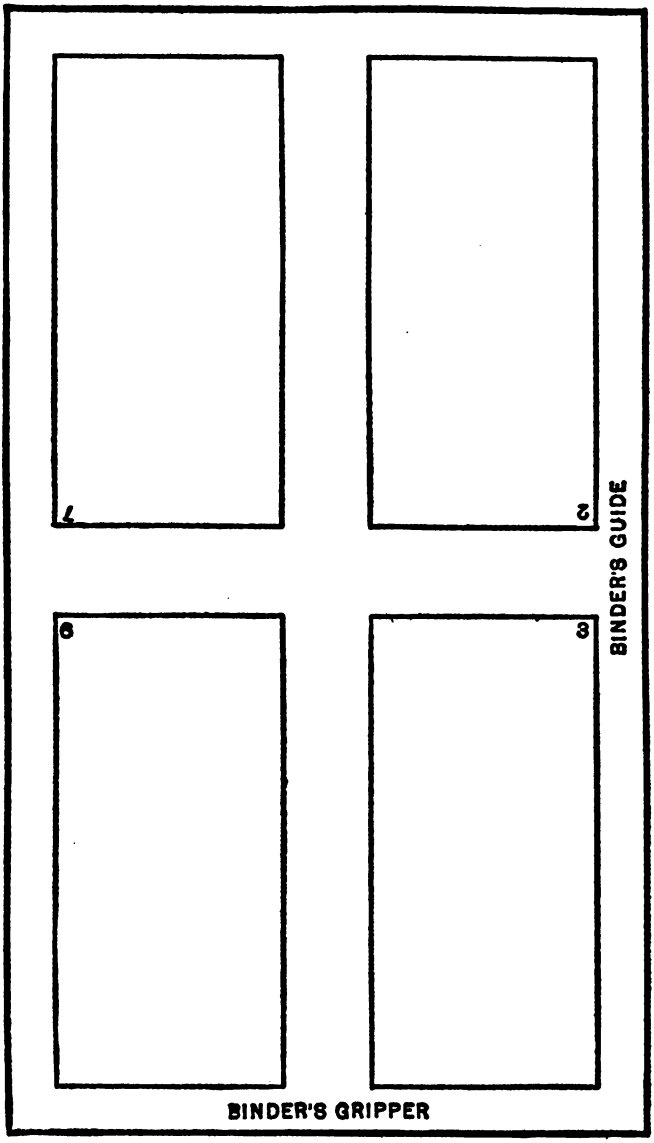
TWO FOLD OUTSIDE FORM



EIGHT PAGES HAND FOLD

(Also Jobber Machine)

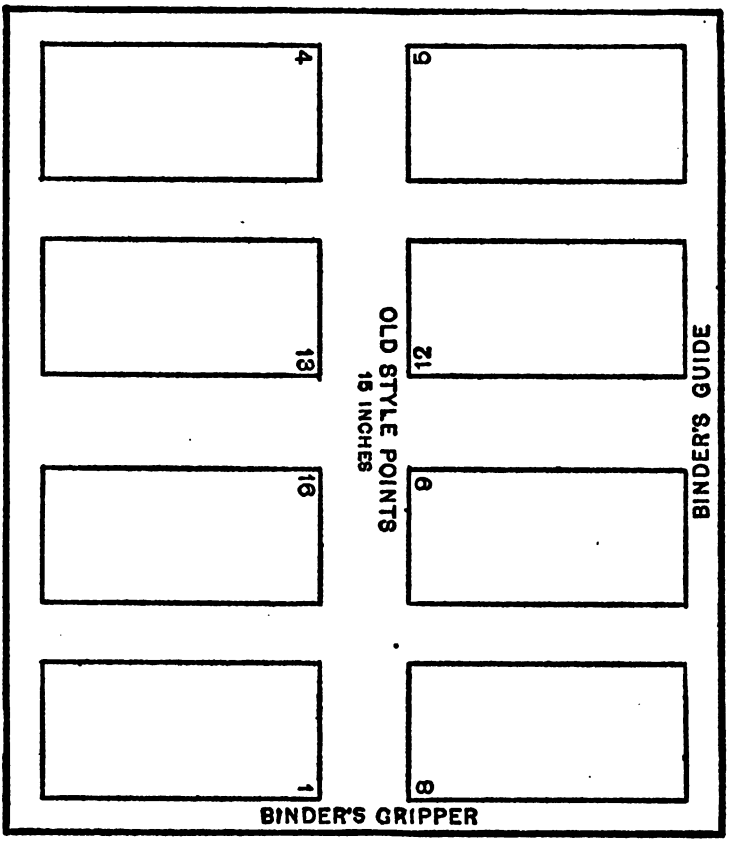
TWO FOLD INSIDE FORM



SIXTEEN PAGE

Jobber or Single Point Machine

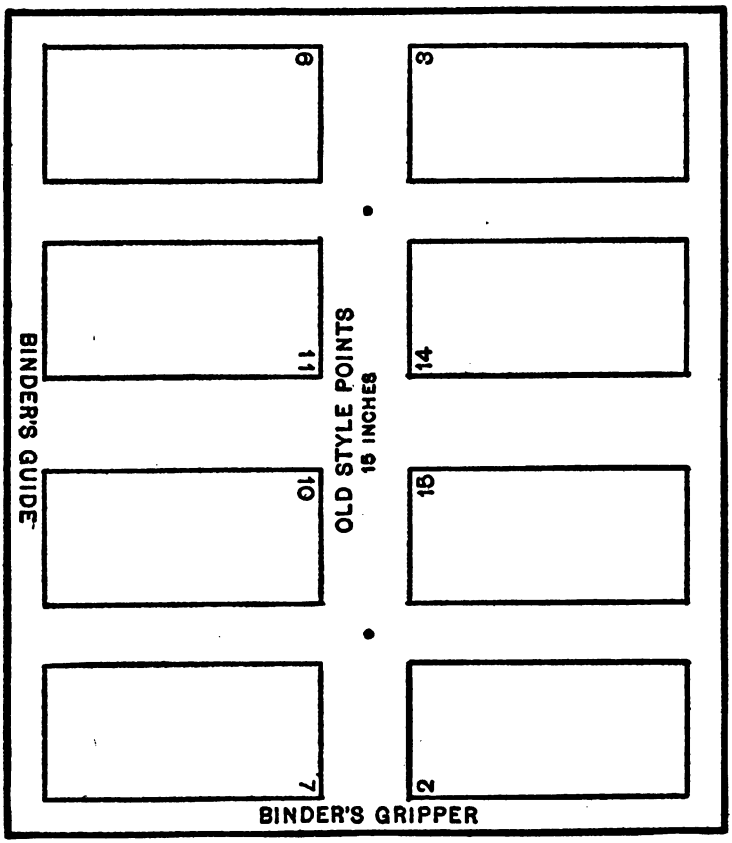
ONE SIGNATURE THREE FOLDS OUTSIDE FORM



SIXTEEN PAGE

Jobber or Single Point Machine

ONE SIGNATURE THREE FOLDS INSIDE FORM

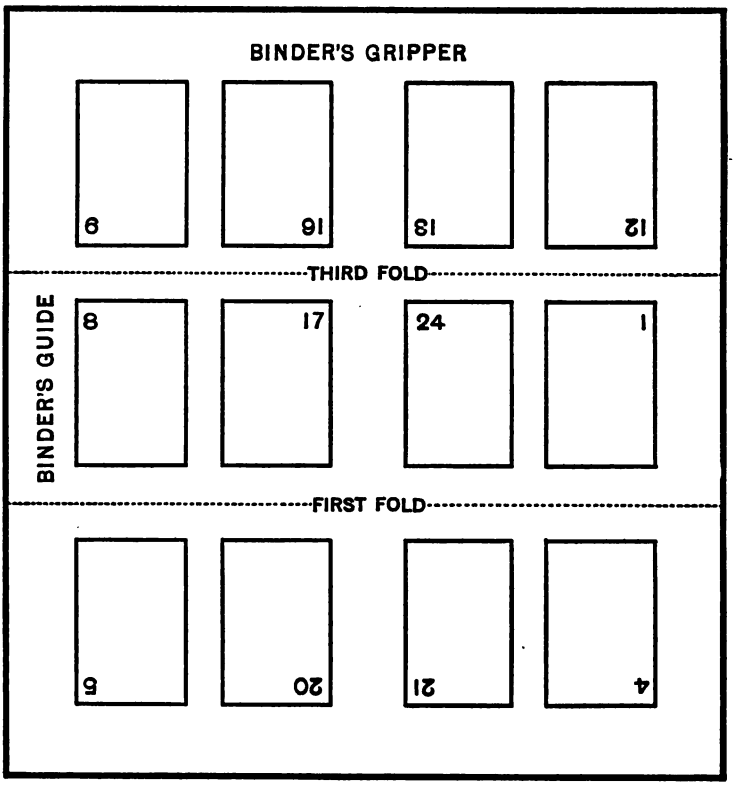


TWENTY-FOUR PAGE

Special Jobber. One Signature.

Four Folds Outside Form

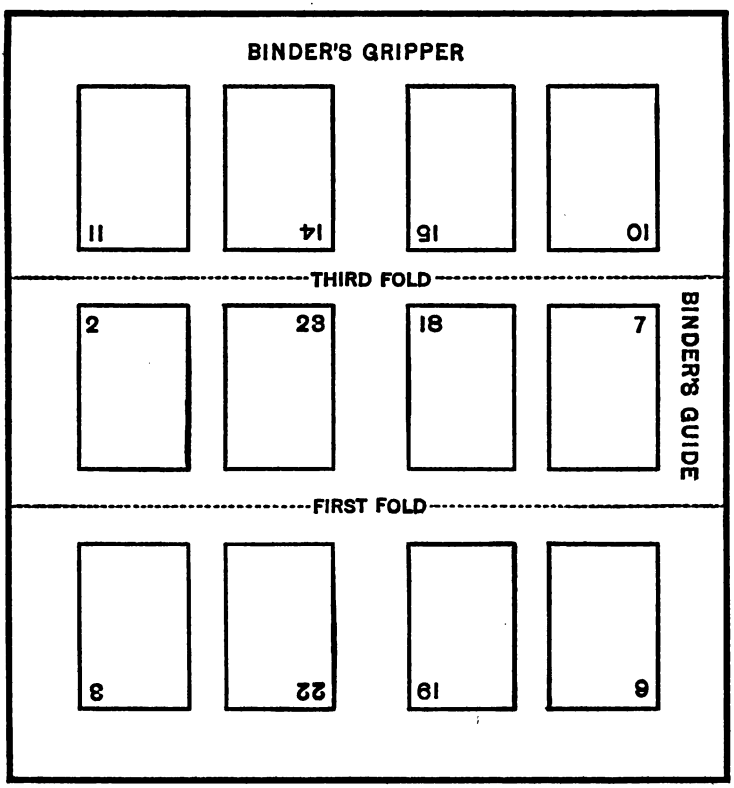
SPECIAL NOTE—As the first fold is a short fold, the length of the sheet as folded must be one-quarter inch away from the folder knife at third fold. Variation of paper must be considered in determining this first fold length.



TWENTY-FOUR PAGE

Special Jobber. One Signature.

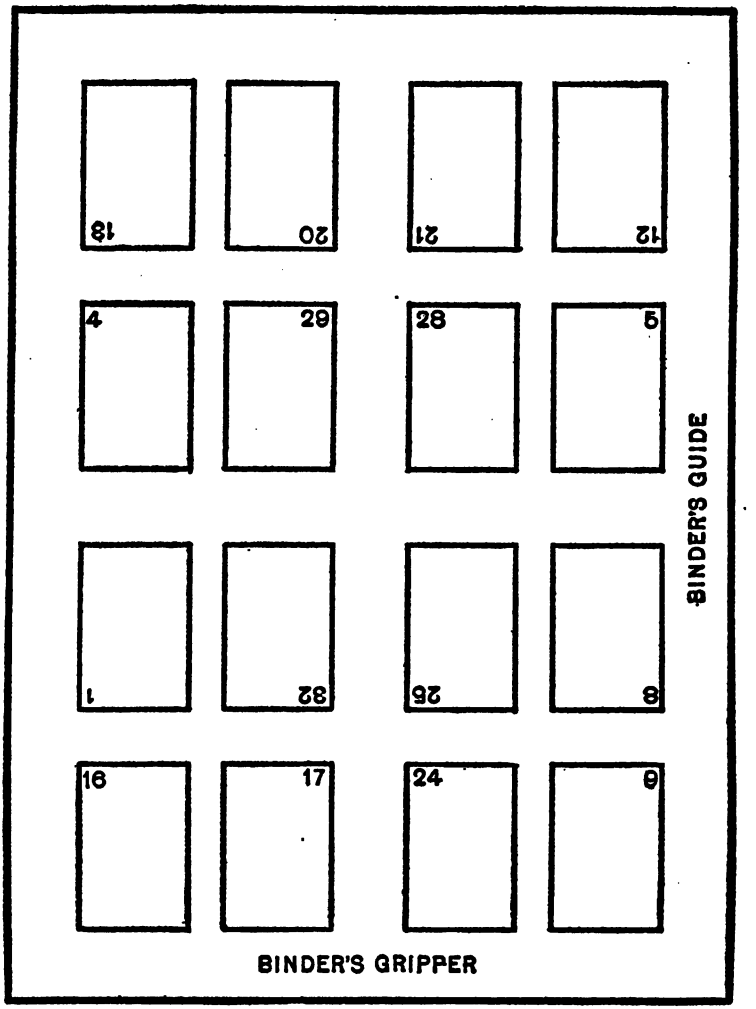
Four Folds Inside Form



THIRTY-TWO PAGE

Special Jobber One Signature

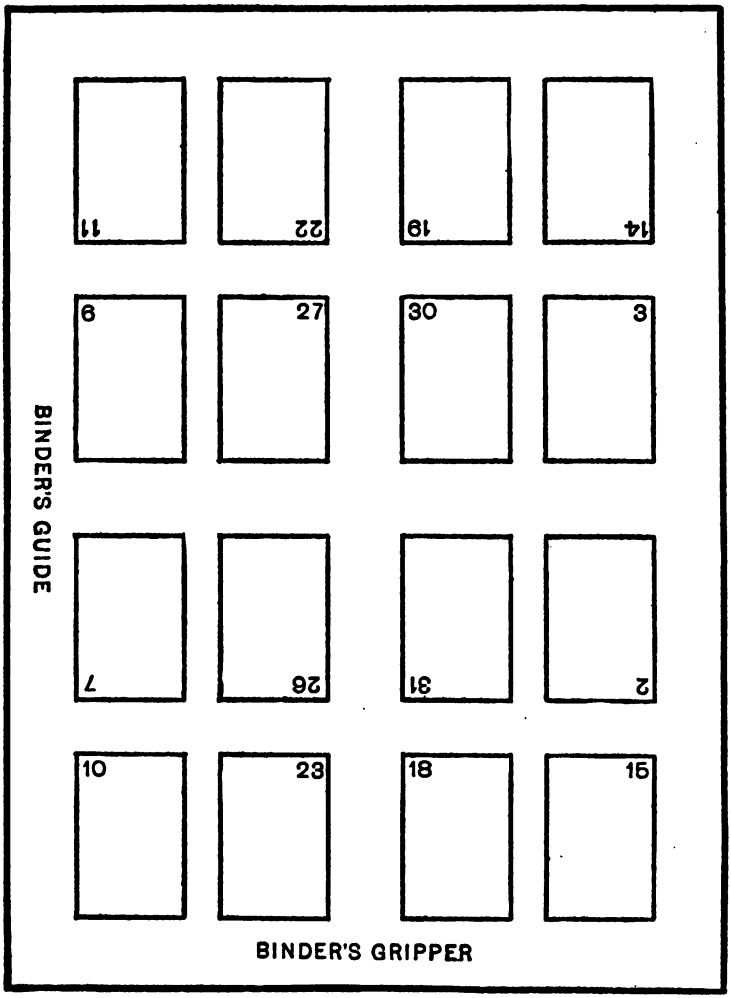
FOUR FOLDS OUTSIDE FORM



THIRTY-TWO PAGE

Special Jobber One Signature

FOUR FOLDS INSIDE FORM

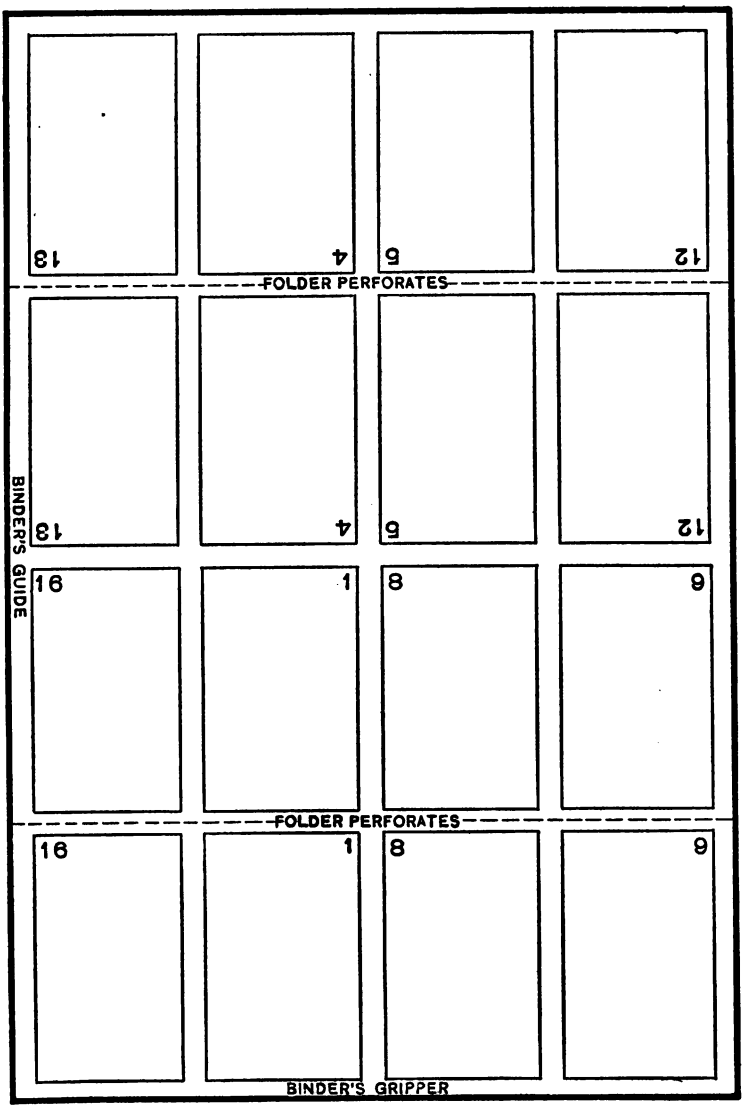


SIXTEEN PAGE

Special Two-up Jobber

Delivering two sixteens folded two-up, one above the other, perforated for separating

Three Folds — Outside Form

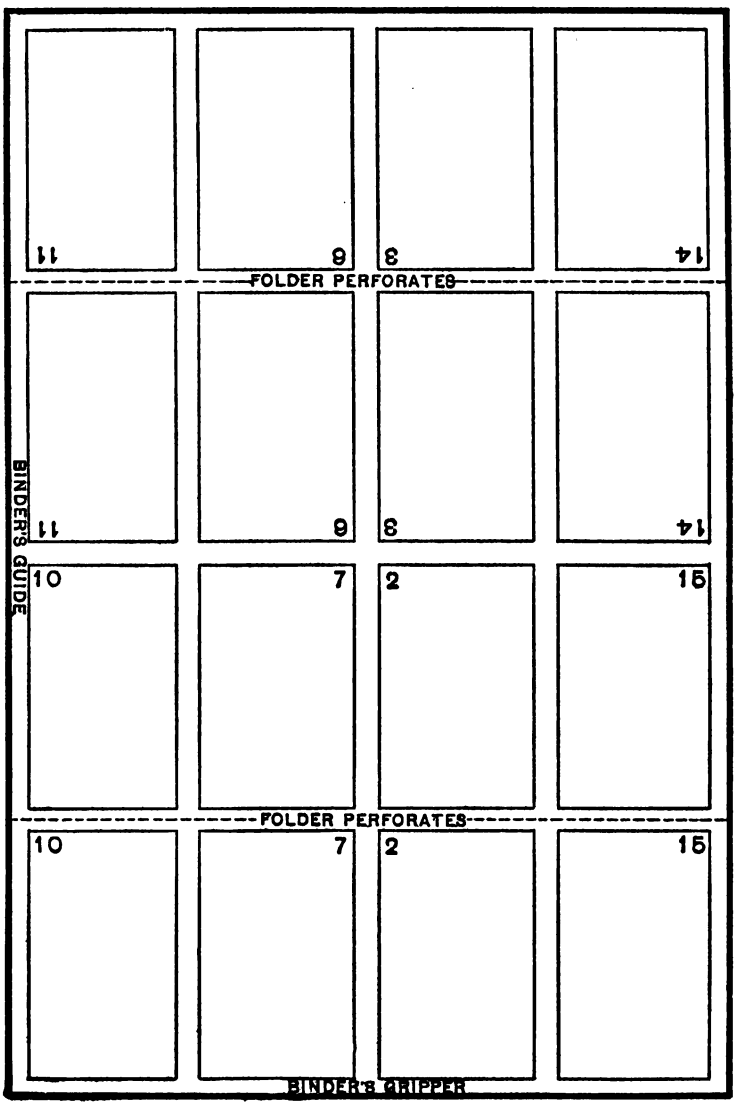


SIXTEEN PAGE

Special Two-up Jobber

Delivering two sixteens folded two-up, one above the other, perforated for separating

Three Folds — Inside Form

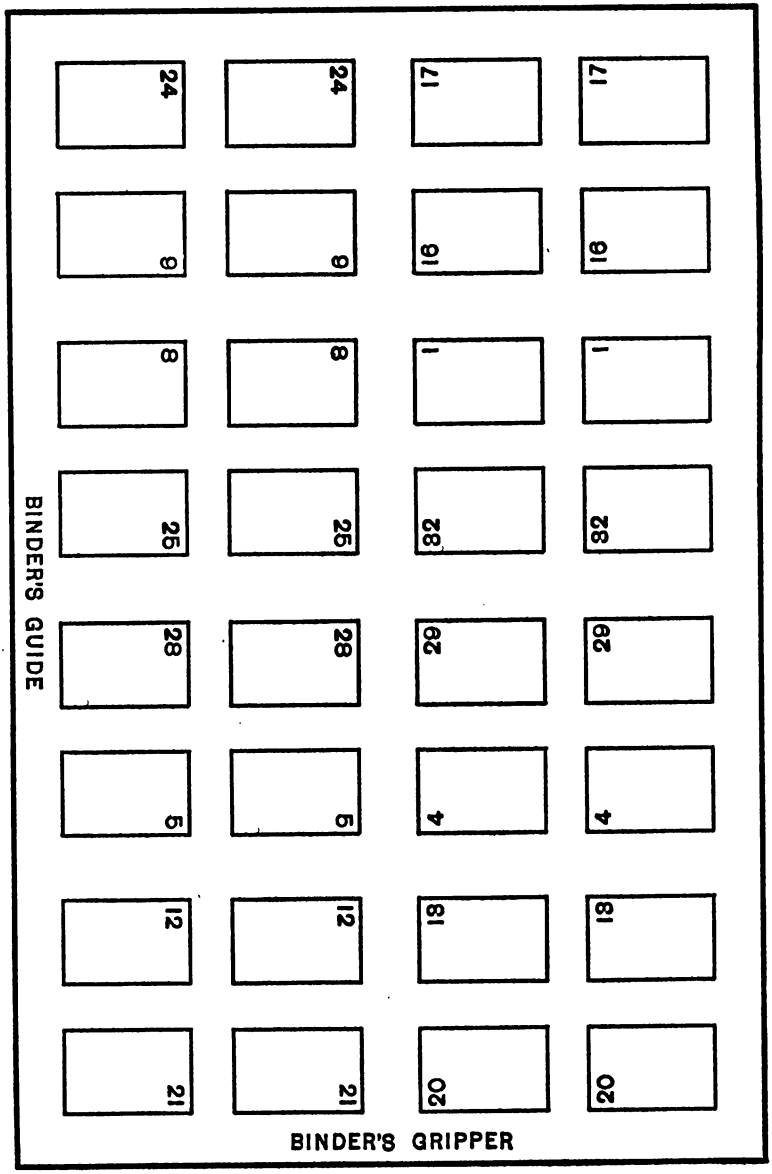


THIRTY-TWO PAGE

Special Two-on Jobber

Delivering two signatures of thirty-two pages each, one above the other.

Four Folds — Outside Form

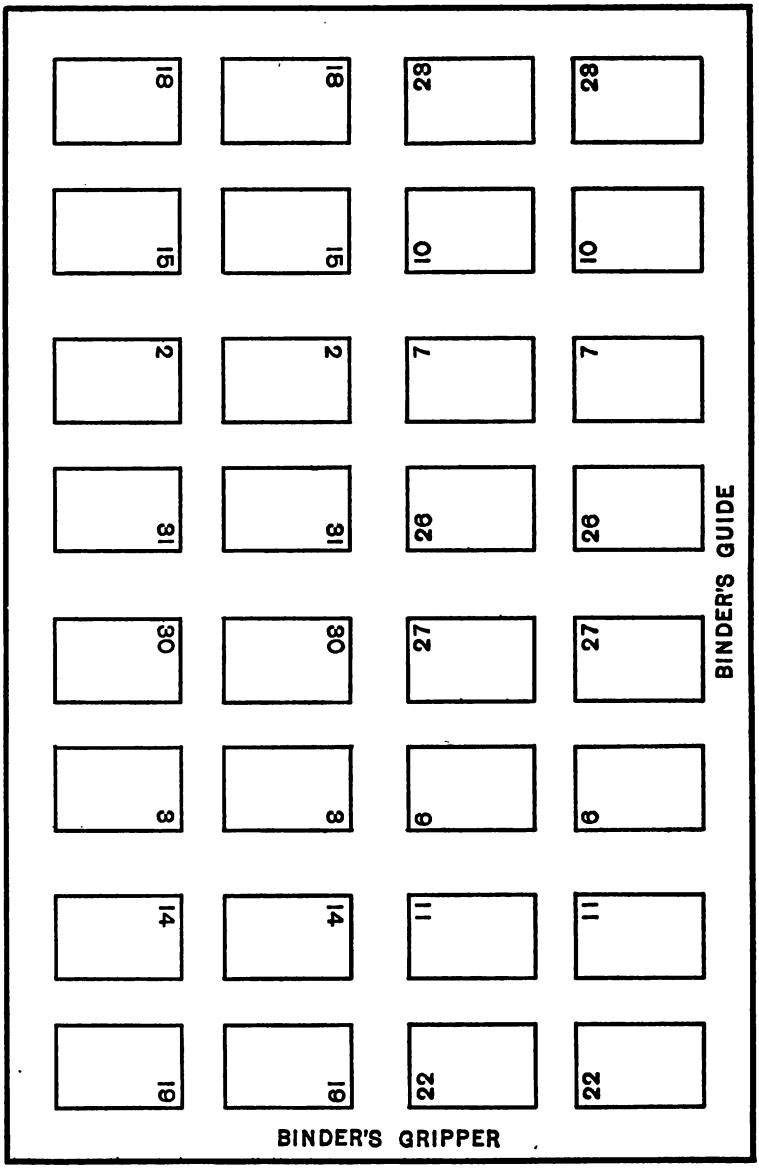


THIRTY-TWO PAGE

Special Two-on Jobber

Delivering two signatures of thirty-two pages each, one above the other.

Four Folds — Inside Form

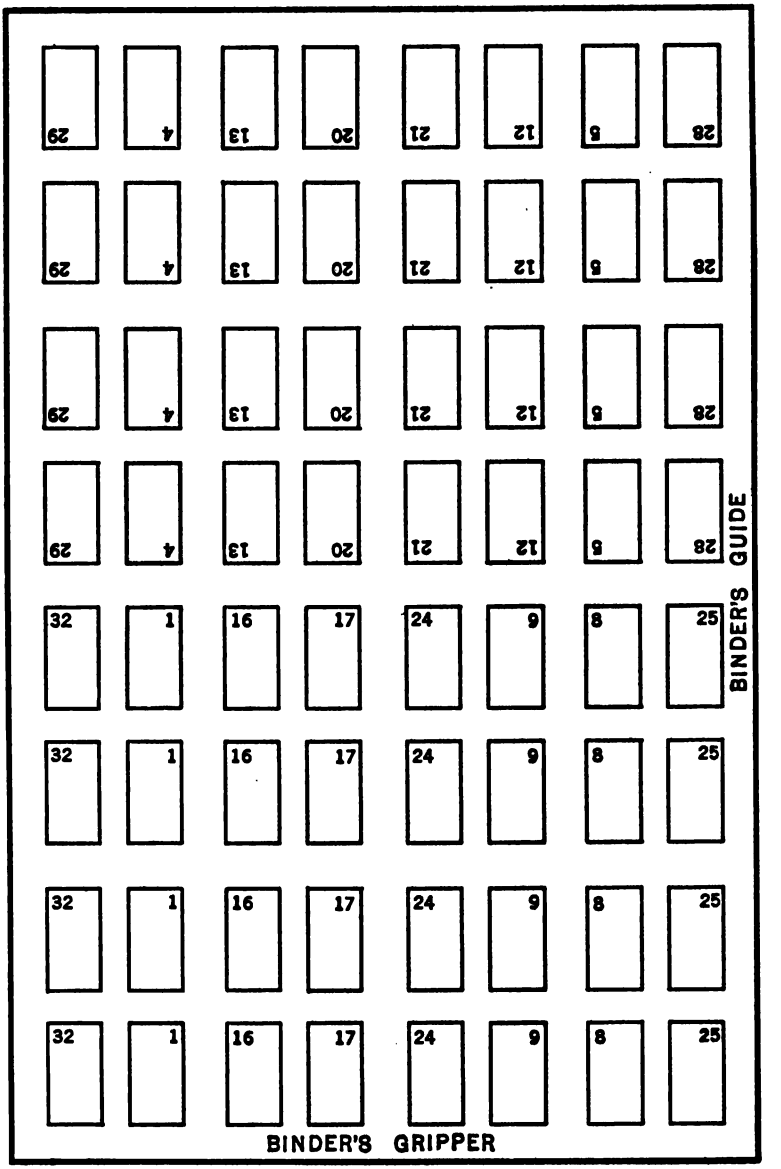


THIRTY-TWO PAGE

Special Four-on Jobber

Delivering four signatures of thirty-two pages each, one above the other.

Four Folds — Outside Form

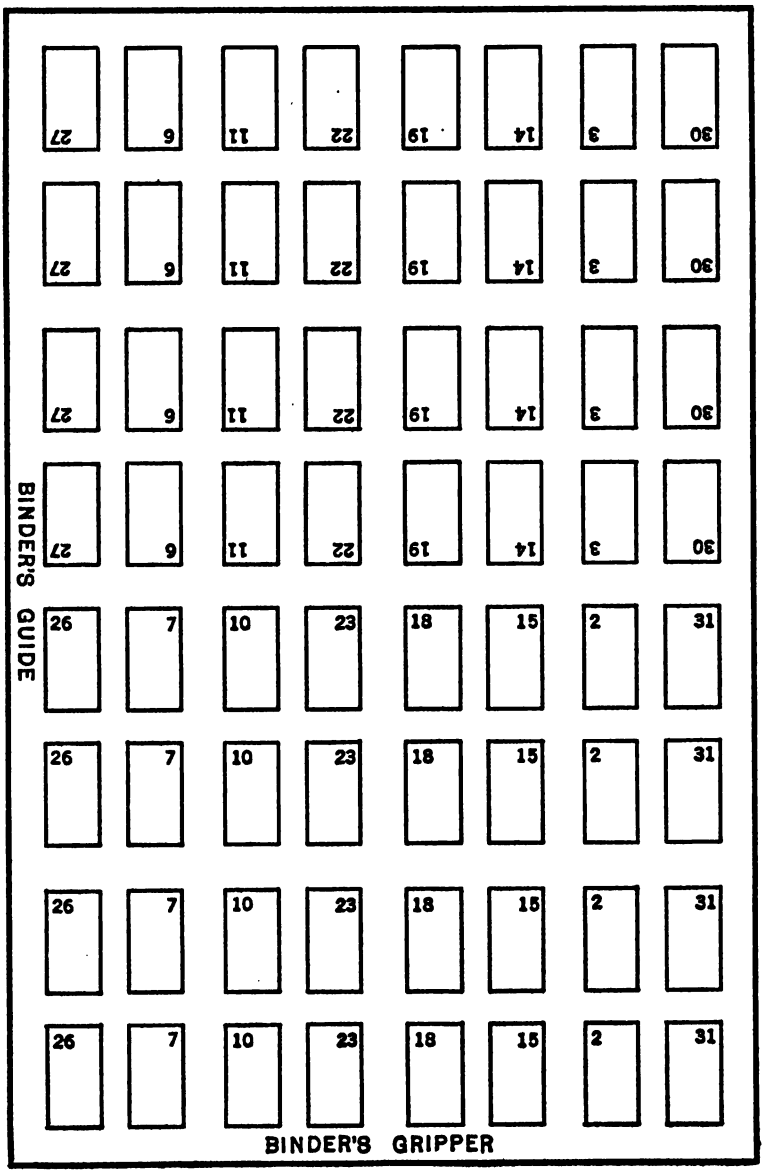


THIRTY-TWO PAGE

Special Four-on Jobber

Delivering four signatures of thirty-two pages each, one above the other.

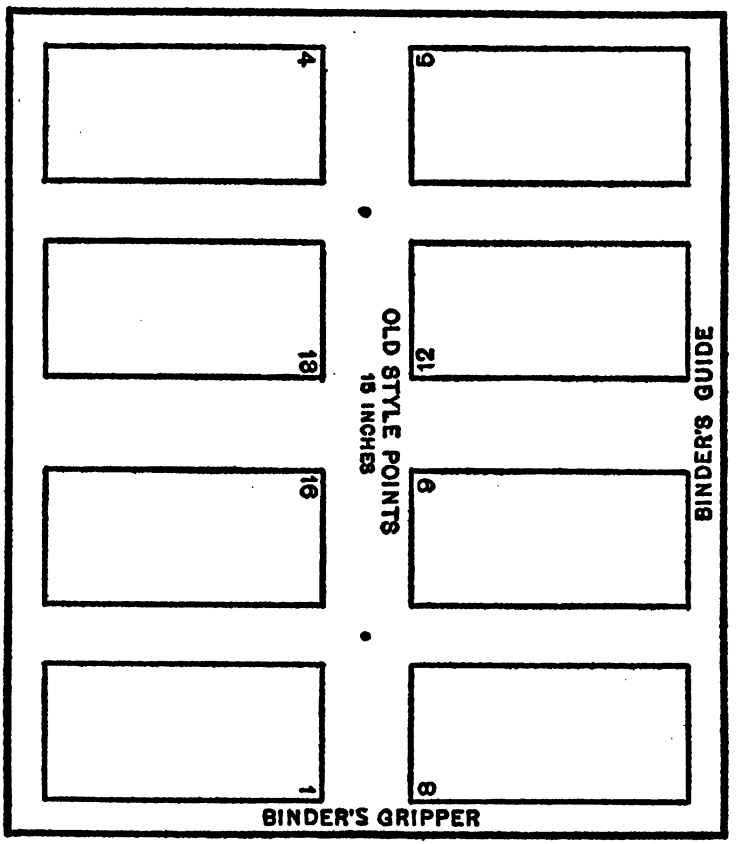
Four Folds **Inside Form**



SIXTEEN PAGE

Jobber or Single Point Machine

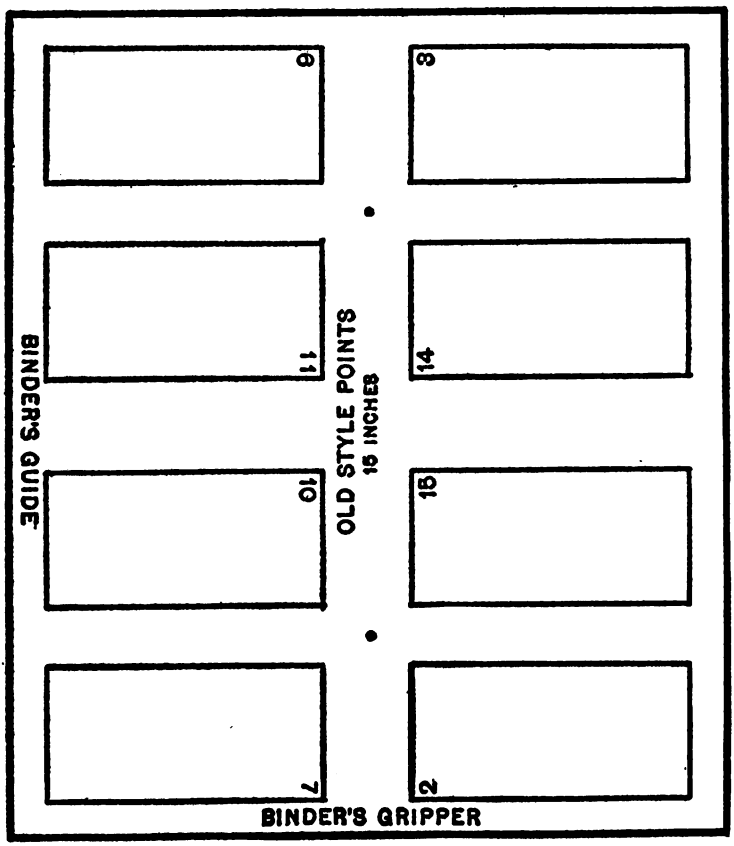
ONE SIGNATURE THREE FOLDS OUTSIDE FORM



SIXTEEN PAGE

Jobber or Single Point Machine

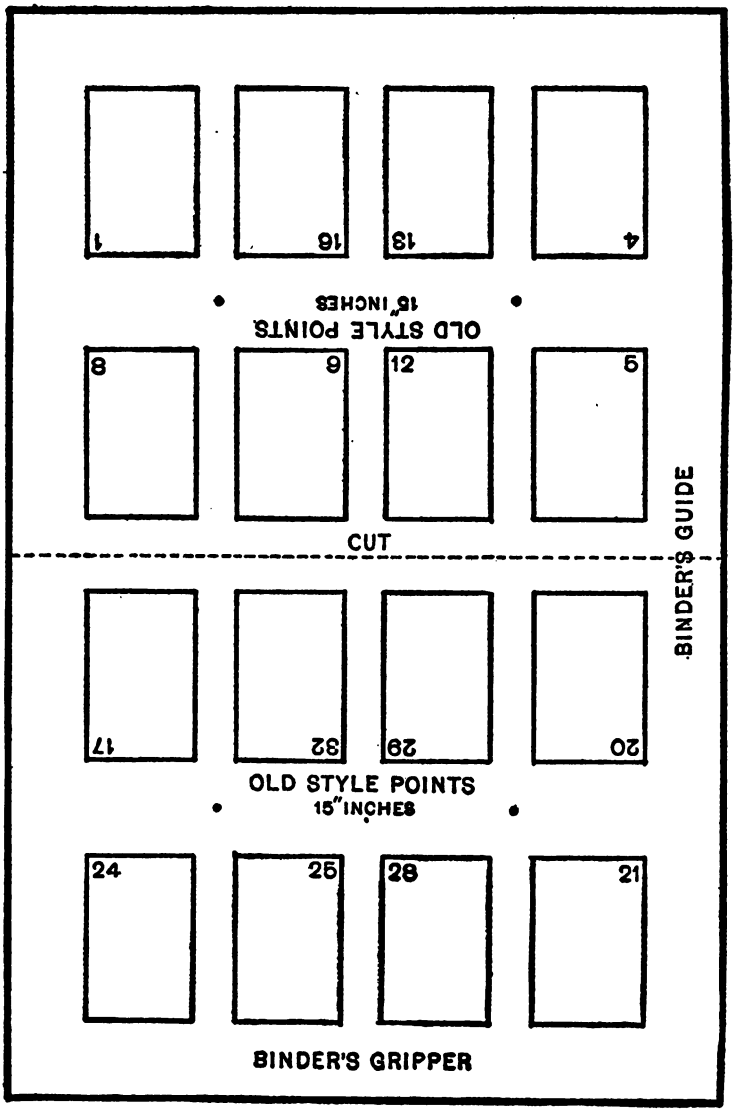
ONE SIGNATURE THREE FOLDS INSIDE FORM



THIRTY-TWO PAGE

Double Point or Drop-Roll Machine

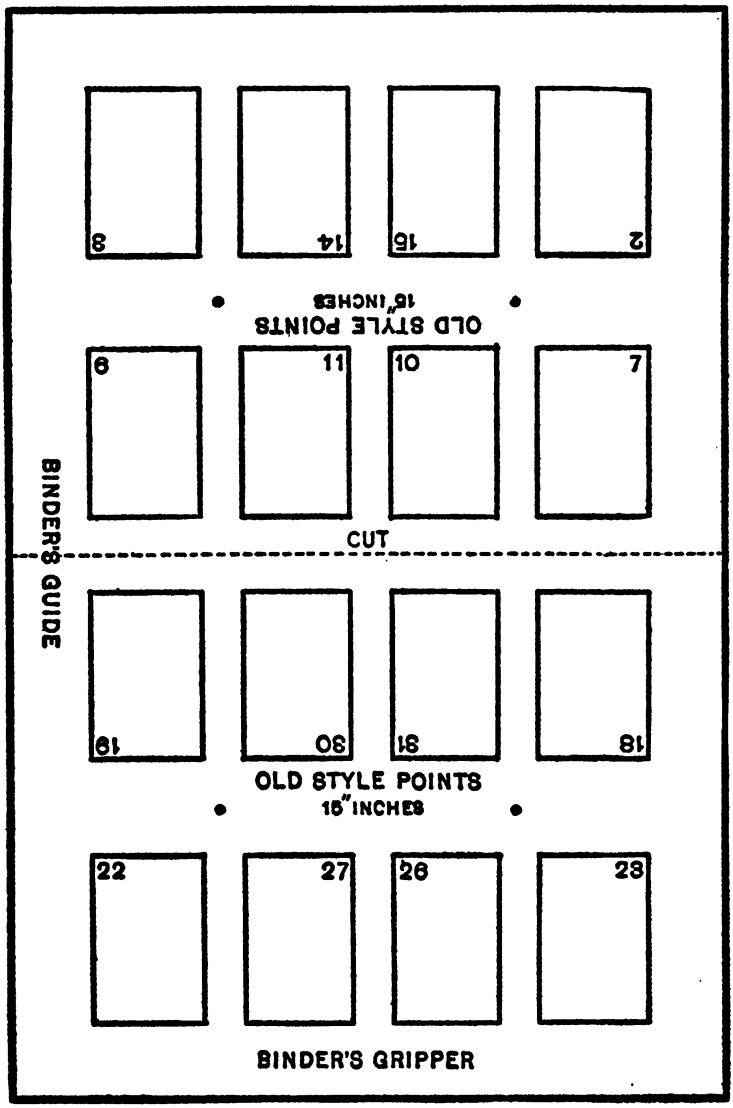
TWO SIGNATURES 16 PAGES THREE FOLDS OUTSIDE FORM



THIRTY-TWO PAGE

Double Point or Drop-Roll Machine

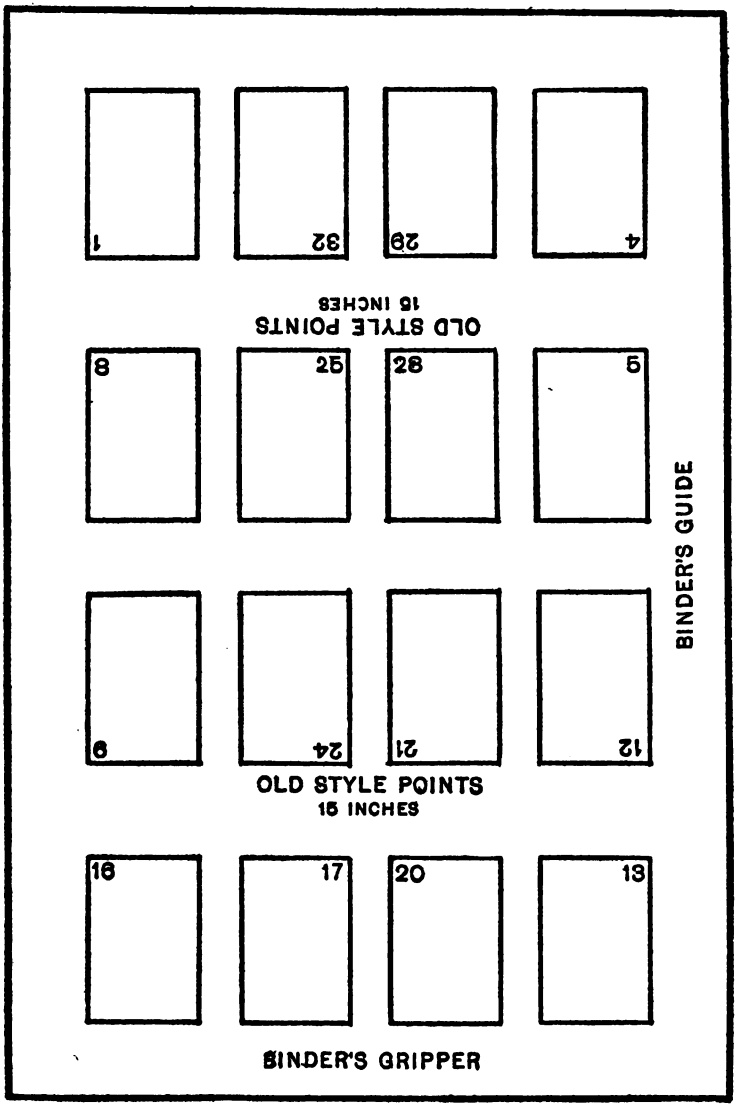
TWO SIGNATURES 16 PAGES THREE FOLDS INSIDE FORM



THIRTY-TWO PAGE

Double Point or Drop-Roll to Insert on Machine. Two Inserted 16 Page Signatures

THREE FOLDS OUTSIDE FORM



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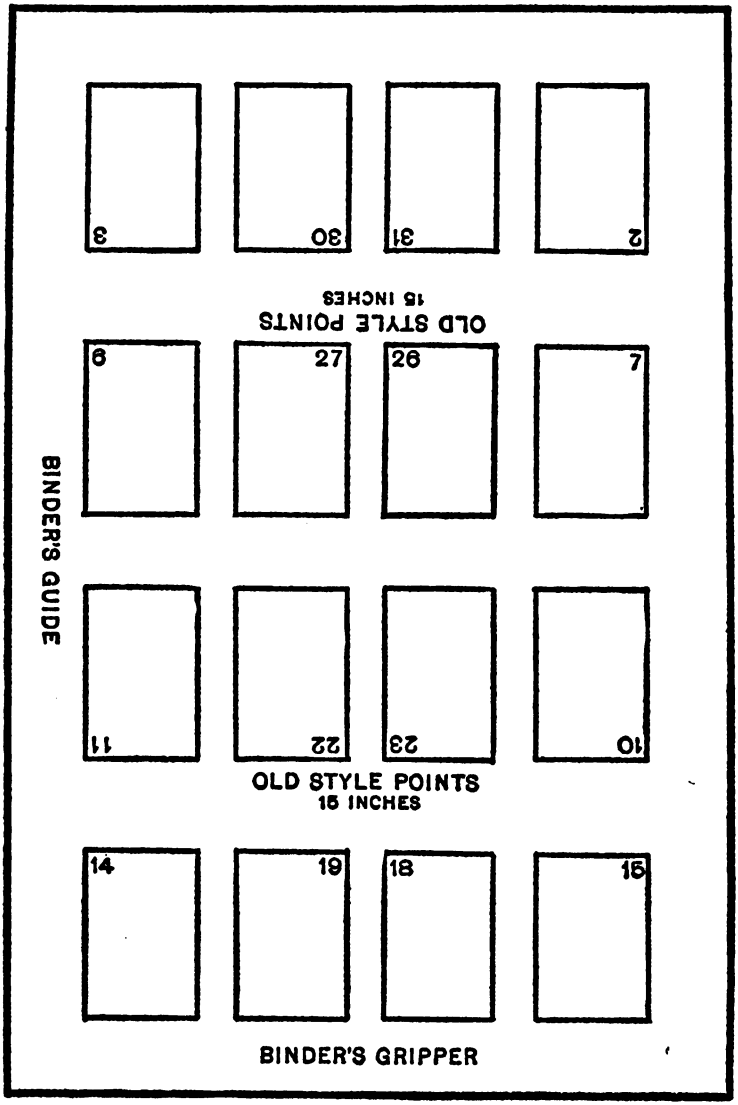
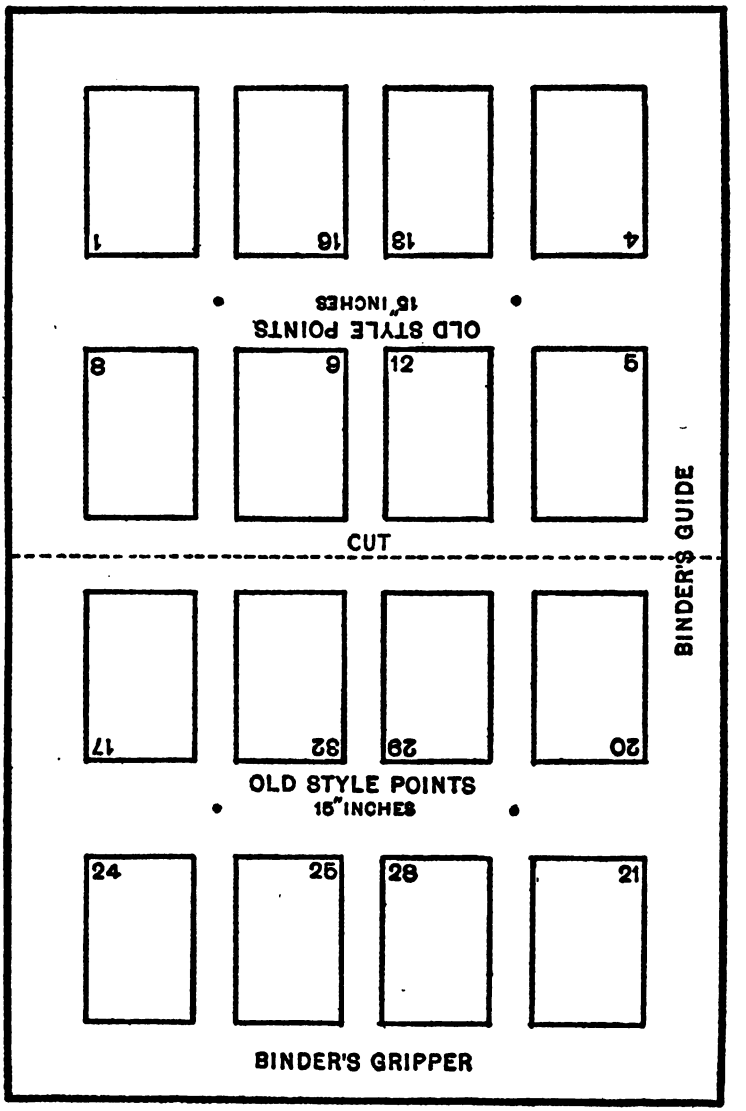
THREE FOLDS INSIDE FORM



THIRTY-TWO PAGE

Double Point or Drop-Roll Machine

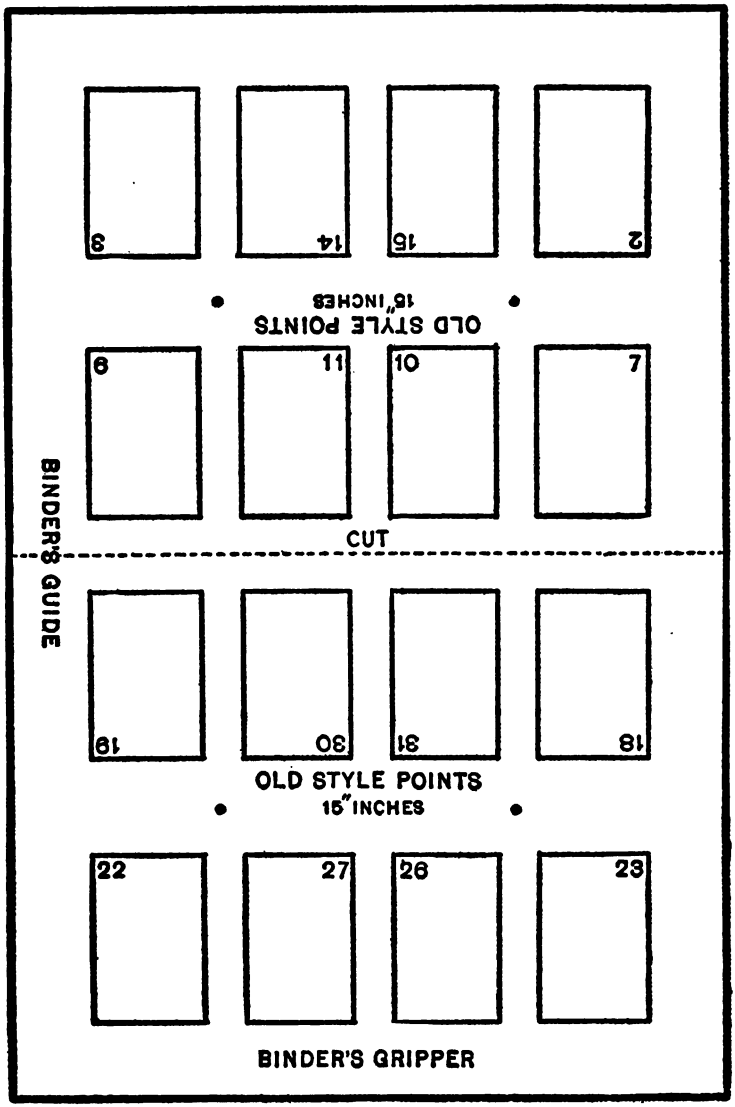
TWO SIGNATURES 16 PAGES THREE FOLDS OUTSIDE FORM



THIRTY-TWO PAGE

Double Point or Drop-Roll Machine

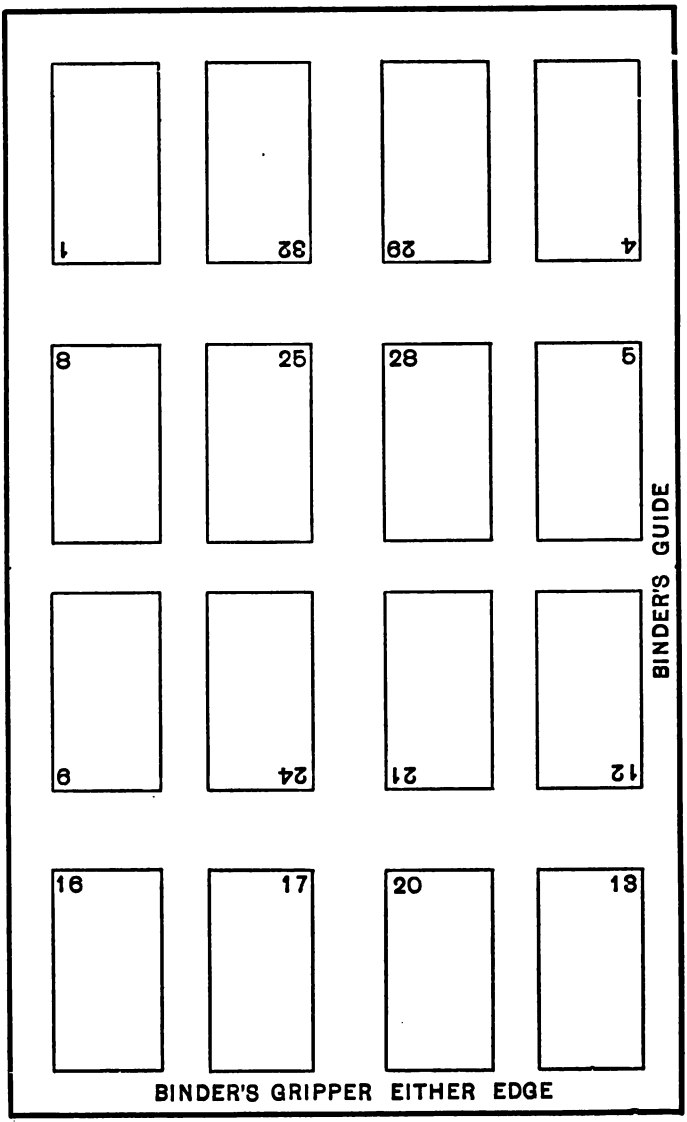
TWO SIGNATURES 16 PAGES THREE FOLDS INSIDE FORM



THIRTY-TWO PAGE

Double Point or Drop-Roll to Insert on Machine. Two Inserted 16 Page Signatures

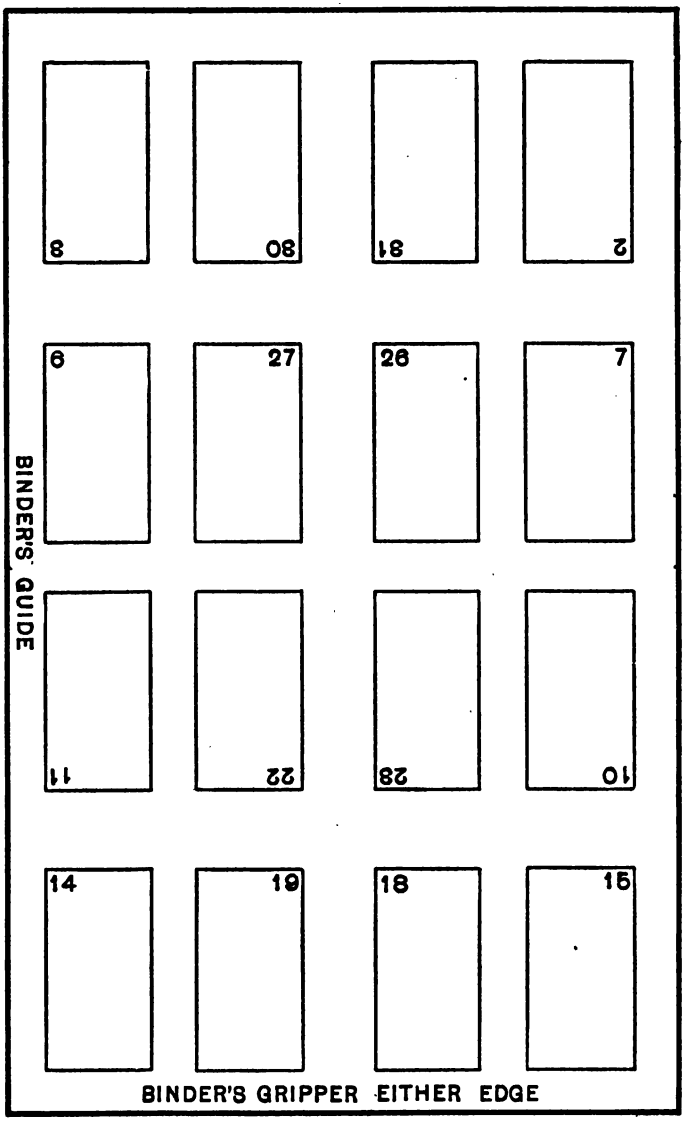
Three Folds — Outside Form



THIRTY-TWO PAGE

Double Point or Drop-Roll to Insert on Machine. Two Inserted 16 Page Signatures

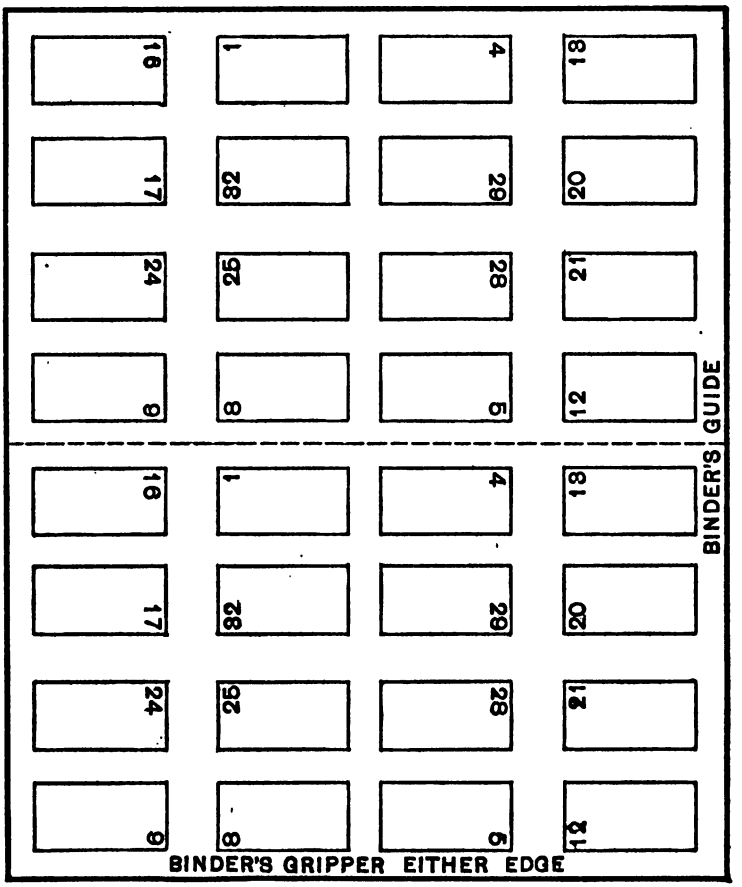
Three Folds — Inside Form



SIXTY-FOUR PAGE

Double Thirty-two, Dexter or Chambers

Folding and delivering two separate 32-page signatures
Outside Form



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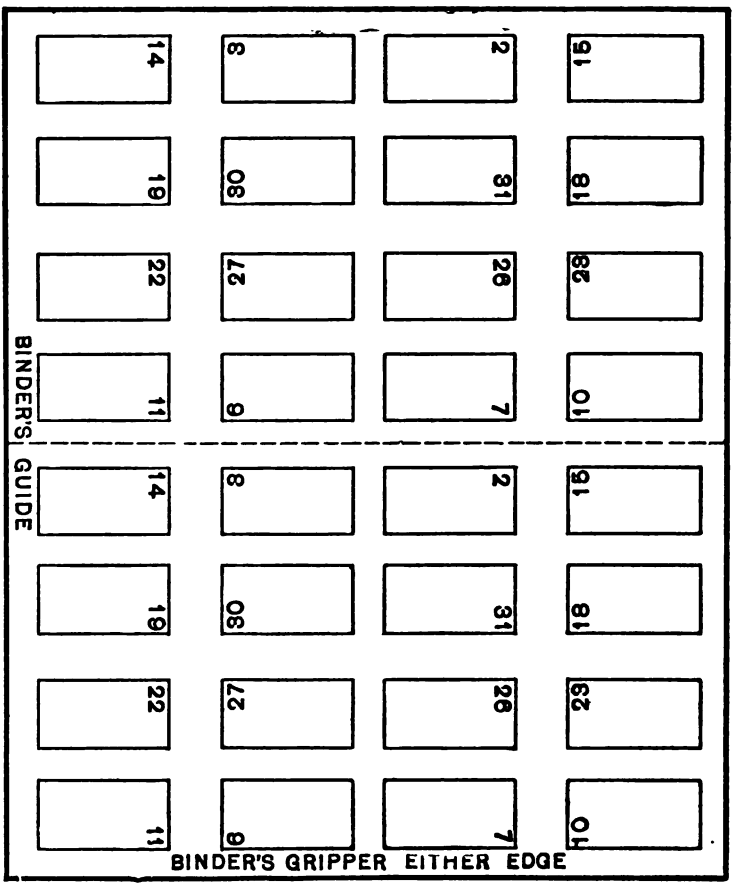
Double Thirty-two, Dexter or Chambers

Folding and delivering two separate 32-page signatures
Inside Form

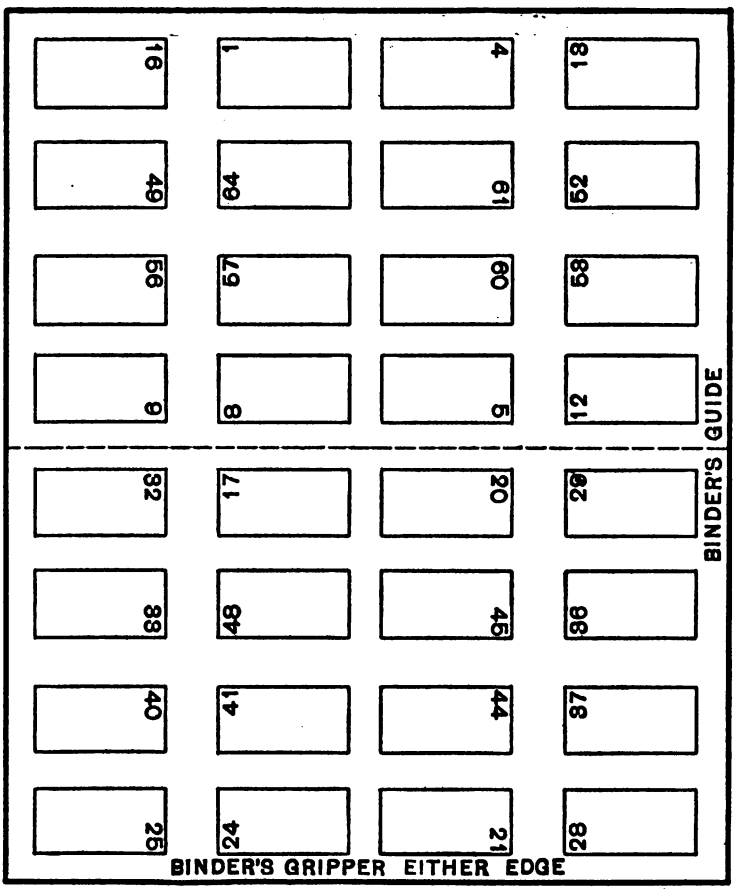


SIXTY-FOUR PAGE

Double Thirty-two, Chambers Machine

Folding and delivering a 64-page signature made up of two 32-page sections folded separately and inserted before Fourth or last fold is made

Outside Form



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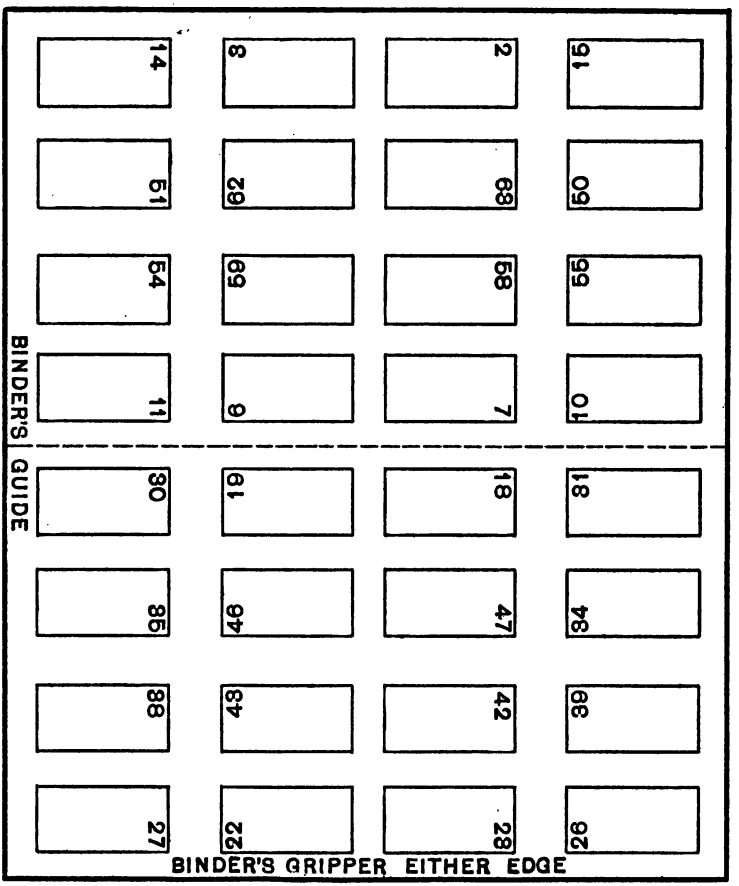
Inside Form

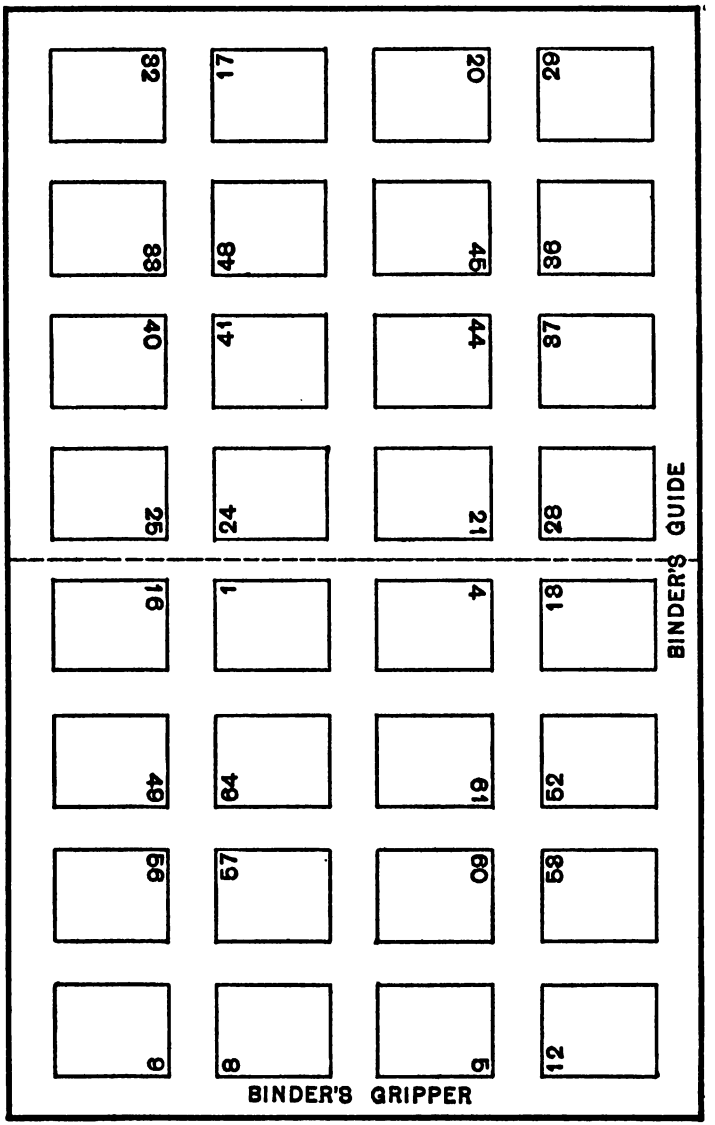


SIXTY-FOUR PAGE

Double Thirty-two, Dexter Machine

Folding and delivering a 64-Page signature made up of two 32-page sections folded separately and inserted after fourth or last fold is made

Outside Form



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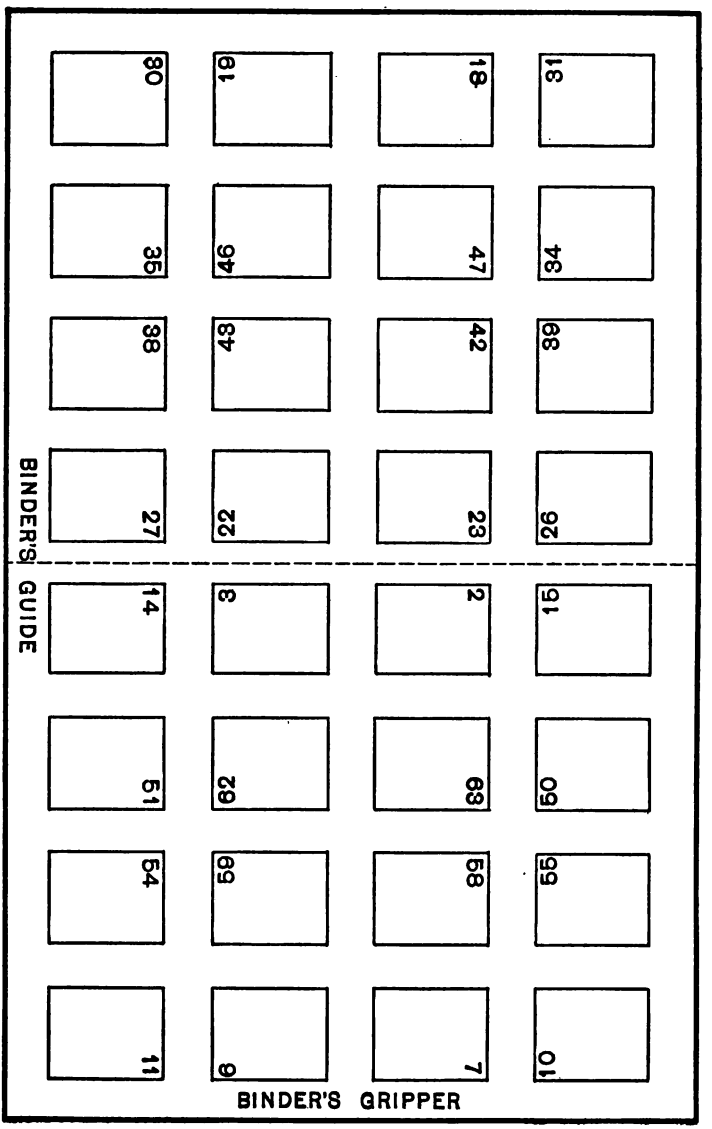
Inside Form

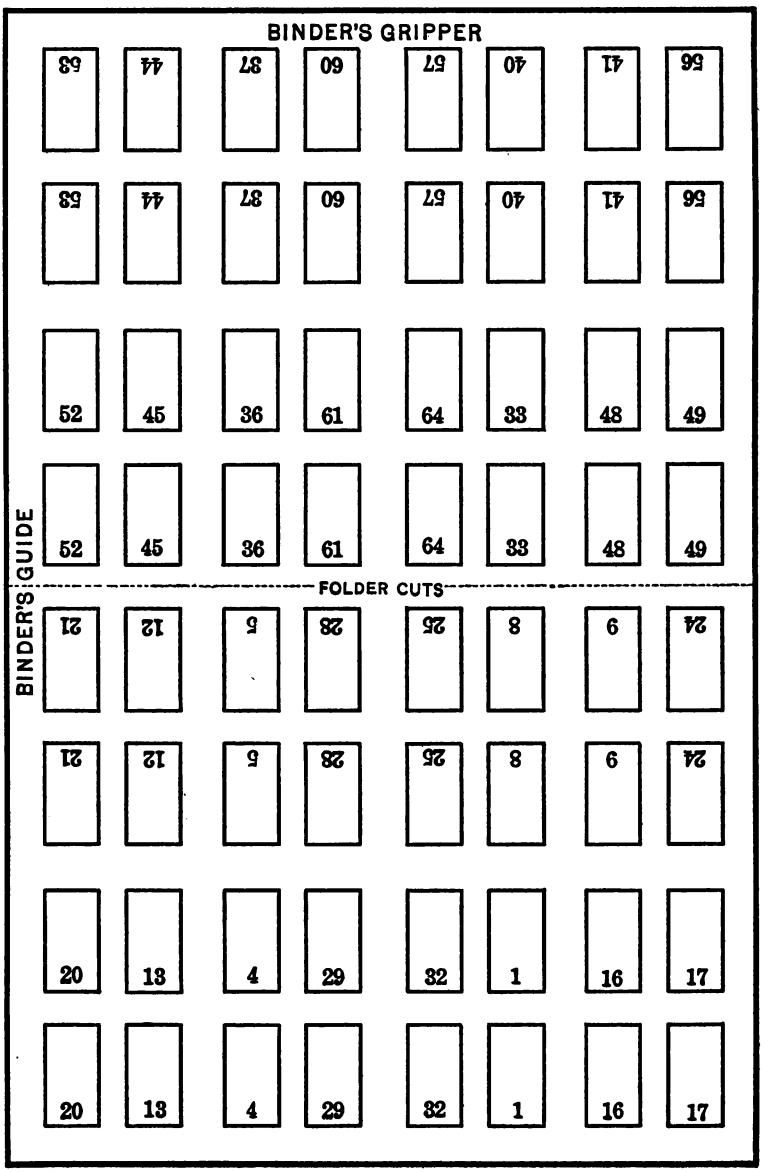


THIRTY-TWO PAGE

Special Two-on Dexter

Delivering two signatures of thirty-two pages each, one above the other.

Four Folds — Outside Form



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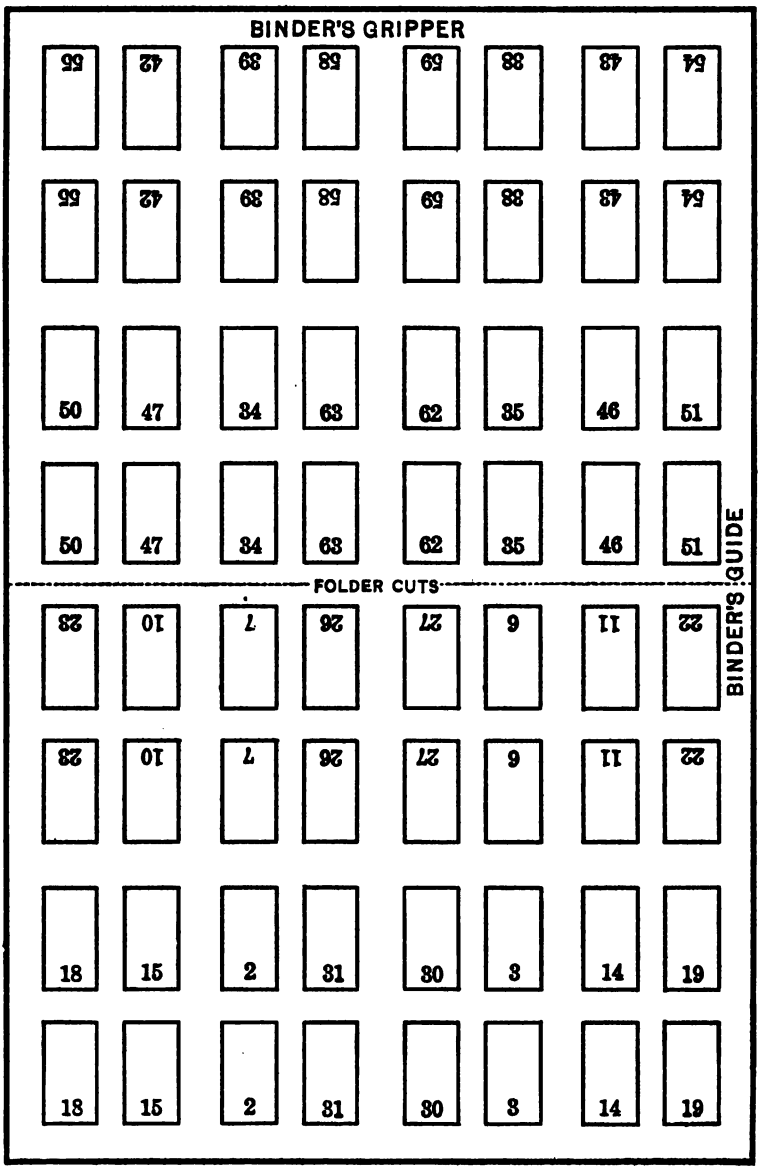
Four Folds **Inside Form**

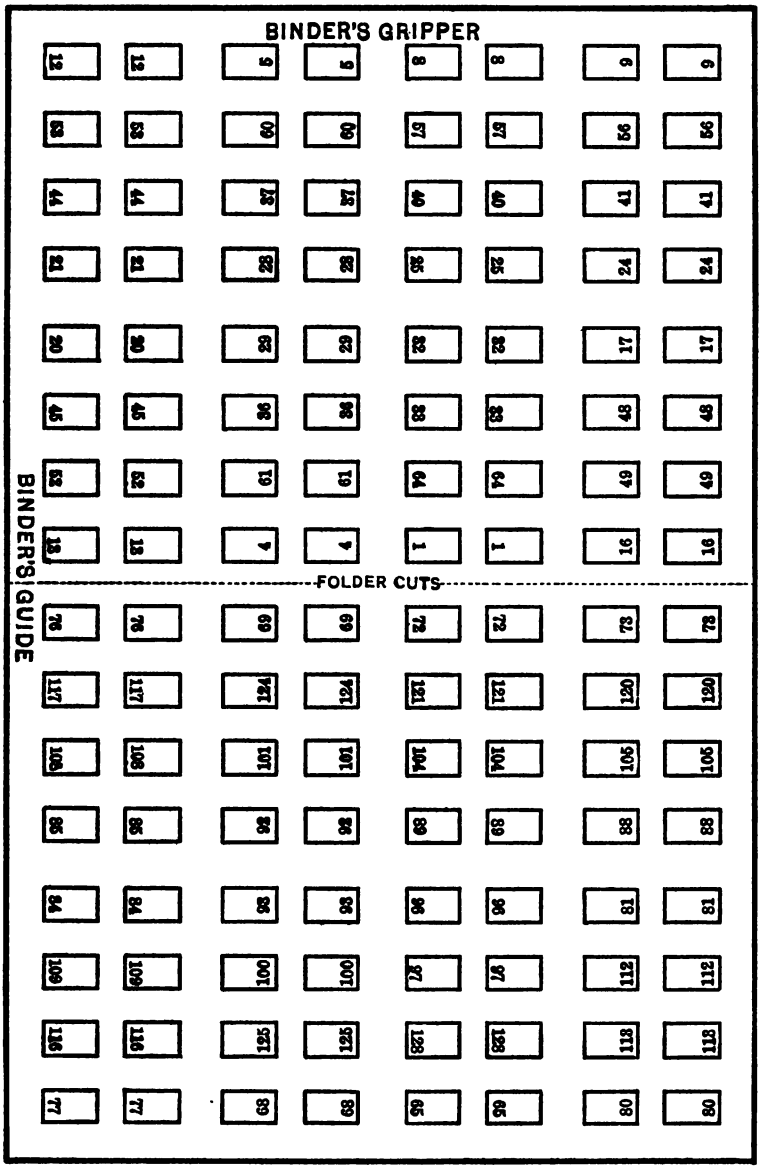


SIXTY-FOUR PAGE

Special Two-on Dexter

Delivering two signatures of sixty-four pages each, one above the other.

Five Folds **Outside Form**

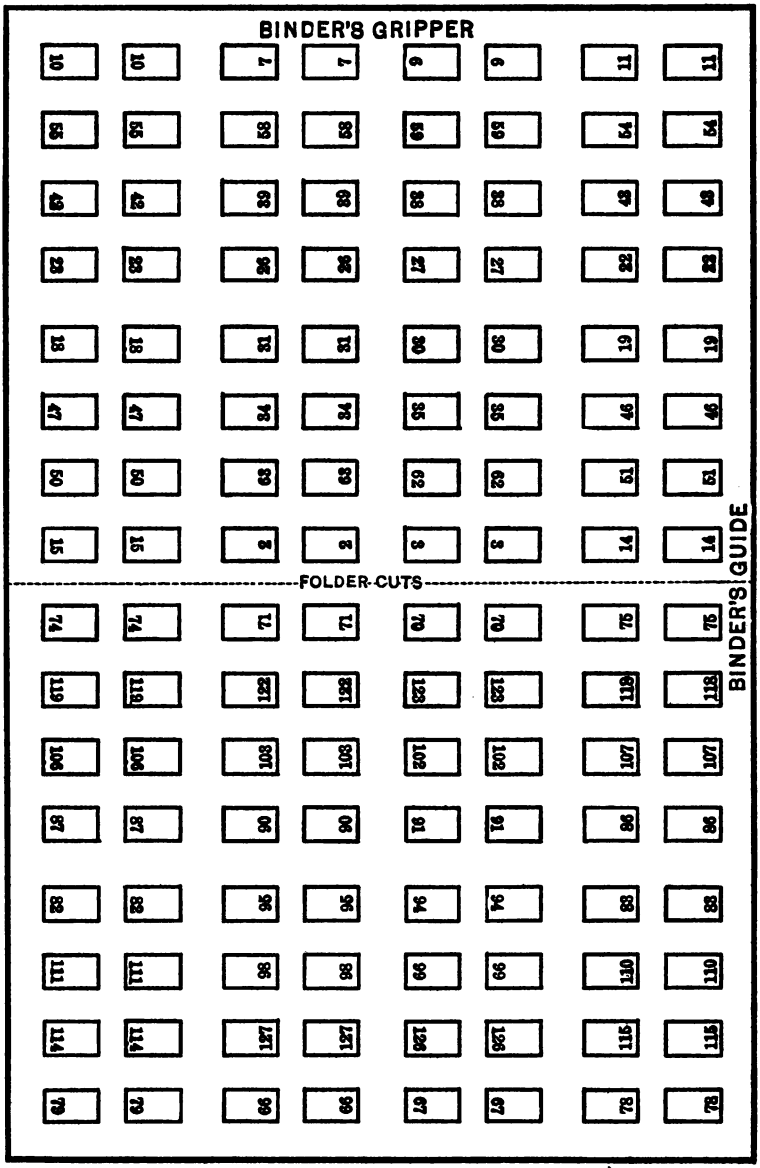


SIXTY-FOUR PAGE

Special Two-on Dexter

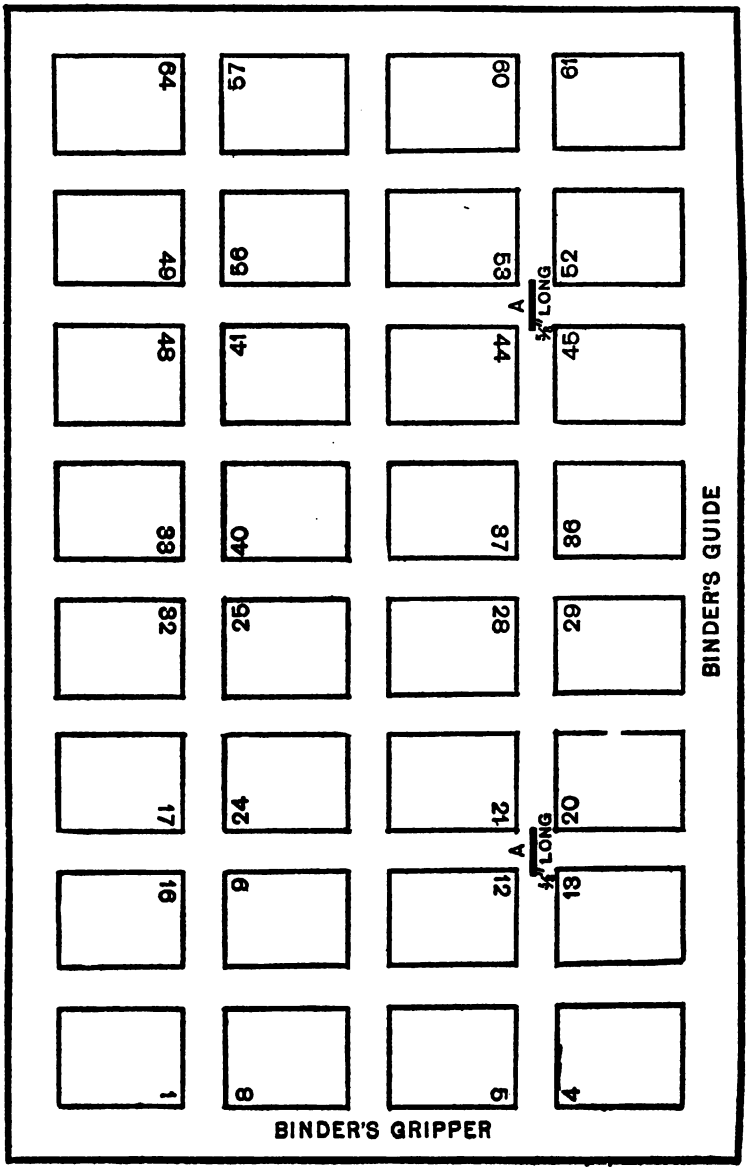
Delivering two signatures of sixty-four pages each, one above the other

Five Folds **Inside Form**

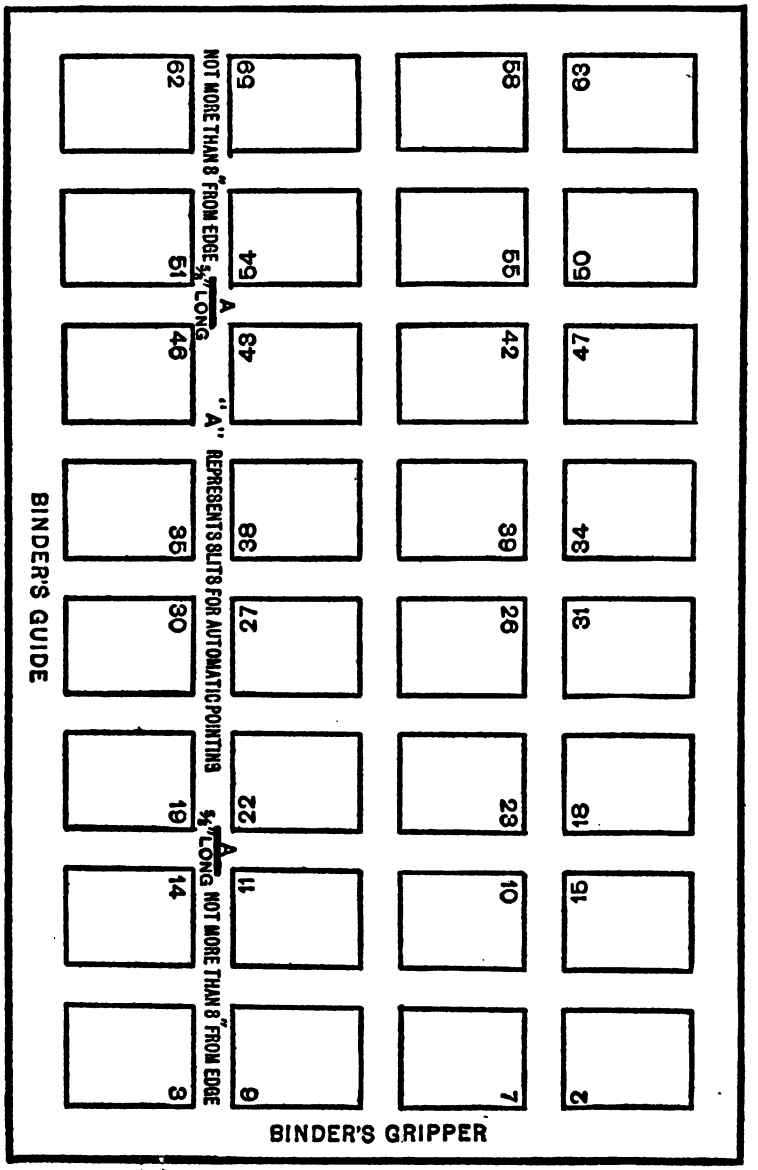


SIXTY-FOUR PAGE QUADRUPLE

FOUR SIGNATURES THREE FOLDS OUTSIDE FORM



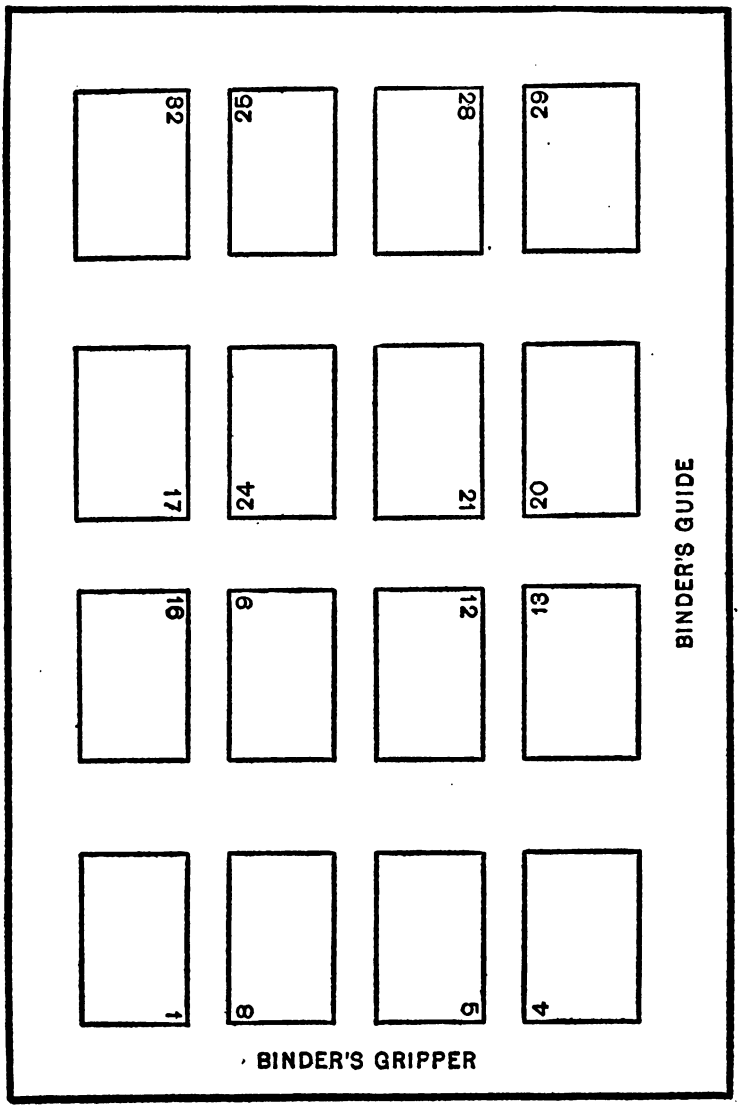
SIXTY-FOUR PAGE QUADRUPLE



THIRTY-TWO PAGE

Quadruple Machine **Oblong Fold** **Two Signatures 16 Pages**

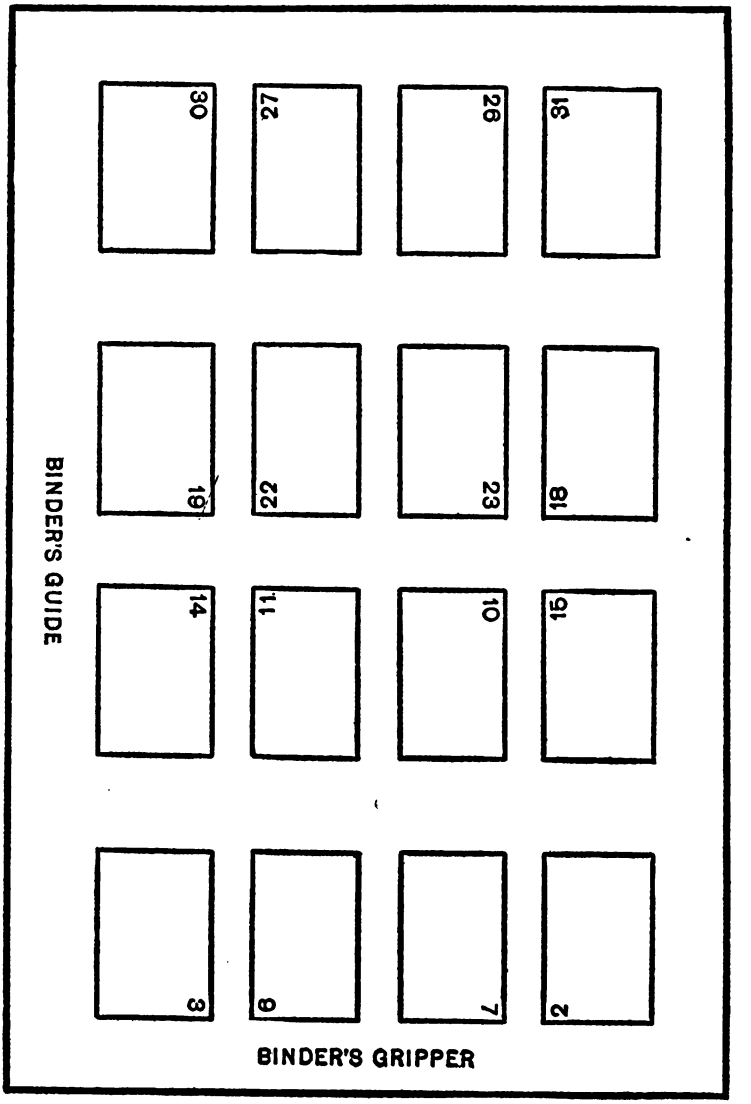
THREE FOLDS OUTSIDE FORM



THIRTY-TWO PAGE

Quadruple Machine Oblong Fold Two Signatures 16 Pages

THREE FOLDS INSIDE FORM



SPECIAL QUADRUPLE

128 Page Sheet

Made up of four units of two sets of 16-Page signatures each, one above the other

Three Folds — Outside Form

BINDER'S GRIPPER

4	13	12	5	8	9	16	1
4	13	12	5	8	9	16	1

FOLDER CUTS HERE

20	29	28	21	24	25	32	17
20	29	28	21	24	25	32	17

FOLDER CUTS HERE

36	45	44	37	40	41	48	33
36	45	44	37	40	41	48	33

FOLDER CUTS HERE

52	61	60	53	56	57	64	49
52	61	60	53	56	57	64	49

BINDER'S GUIDE

SPECIAL QUADRUPLE

128 Page Sheet

Made up of four units of two sets of 16-Page signatures each, one above the other

Three Folds — Inside Form

BINDER'S GRIPPER

2	15	10	7	6	11	14	3
2	15	10	7	6	11	14	3

FOLDER CUTS HERE

18	31	26	23	22	27	30	19
18	31	26	23	22	27	30	19

FOLDER CUTS HERE

34	47	42	39	38	43	46	35
34	47	42	39	38	43	46	35

FOLDER CUTS HERE

50	63	58	55	54	59	62	51
50	63	58	55	54	59	62	51

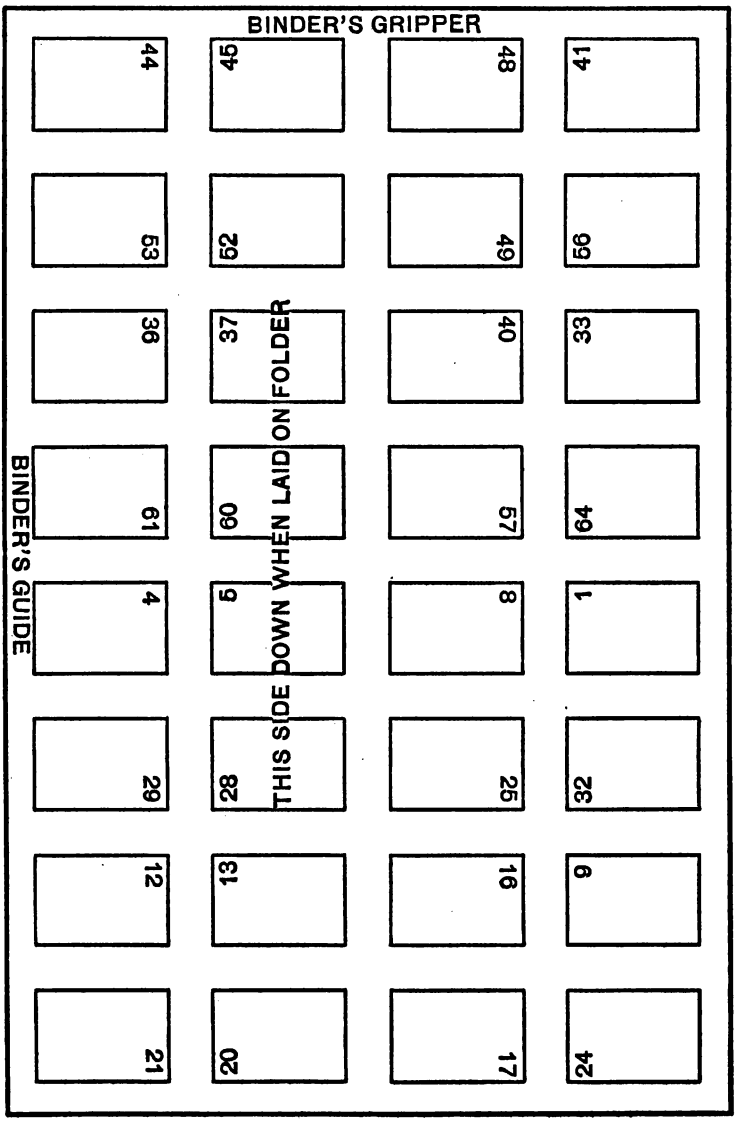
BINDER'S GUIDE

QUADRUPLE INSERT

64 Page Sheet

Four signatures of 16 pages each folded and inserted to give two 32-page sections

Three Folds and Insert — Outside Form



QUADRUPLE INSERT

64 Page Sheet

Four signatures of 16 pages each folded and inserted to give two 32-page sections

Three Folds and Insert — Inside Form

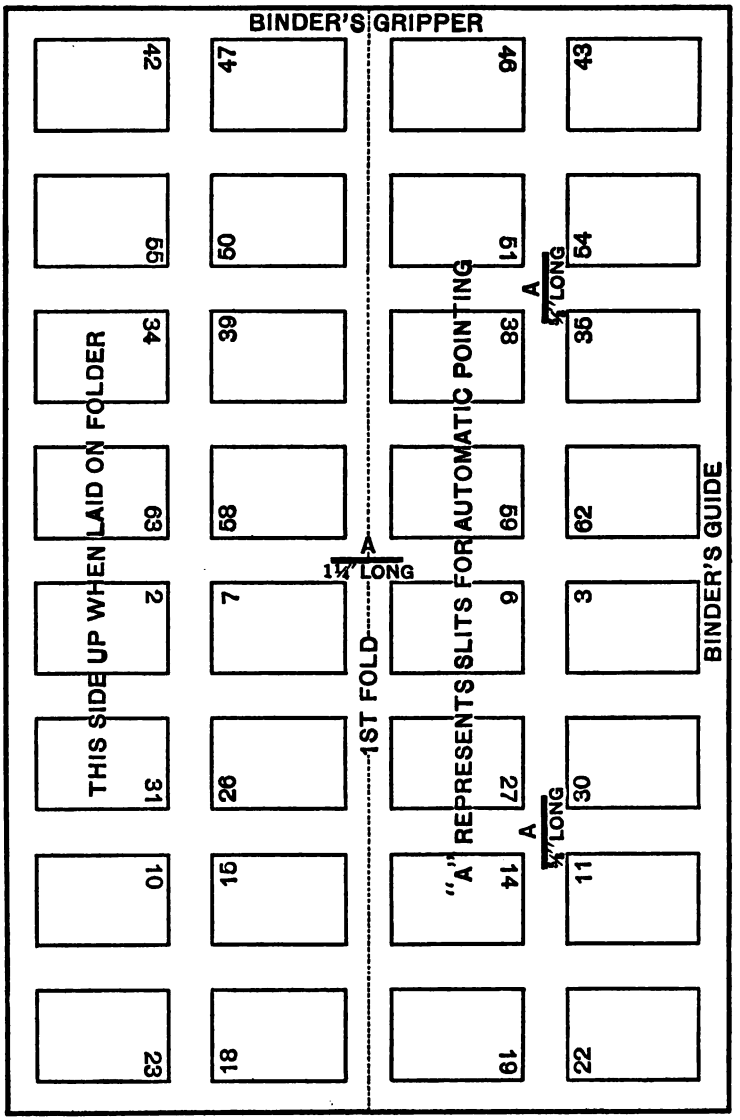


TABLE OF QUANTITIES

of Paper Needed

With five per cent. allowance for waste, in forms of the number of pages on one side of the paper as noted on the top of the columns, based on 1,000 copies.

Pages	8 pp.	12 pp.	16 pp.	24 pp.	32 pp.	48 pp.	64 pp.
4	263	175	132	88	66	44	33
8	525	350	263	175	132	88	66
12	788	525	394	263	197	132	99
16	1050	700	525	350	263	175	32
20	1313	875	657	438	329	219	165
24	1575	1050	788	525	394	263	197
28	1838	1225	919	613	460	307	230
32	2100	1400	1050	700	525	350	263
36	2363	1575	1182	788	591	394	296
40	2625	1750	1313	875	657	438	329
44	2888	1925	1444	963	722	482	361
48	3150	2100	1575	1050	788	525	394
52	3413	2275	1707	1138	854	569	427
56	3675	2450	1838	1225	919	613	460
60	3938	2625	1969	1313	985	657	493
64	4200	2800	2100	1400	1050	700	525
68	4463	2975	2232	1488	1116	744	558
72	4725	3150	2363	1575	1182	788	591
76	4988	3325	2494	1663	1247	832	624
80	5250	3500	2625	1750	1313	875	657
84	5513	3675	2757	1838	1379	919	690
88	5775	3850	2888	1925	1444	963	722
92	6038	4025	3019	2013	1510	1007	755
96	6300	4200	3150	2100	1575	1050	788
100	6563	4375	3282	2188	1641	1094	821

By consulting the above table the amount of paper necessary for any given job may be readily and surely determined. If on a given size of paper twenty-four pages can be printed on one side of the sheet, the paper necessary for 1,000 copies of a 100-page book will be 2,188 sheets, and if the book should be 196 pages, you will add the 2,100 additional sheets, making the total 4,288 sheets.

Figuring in the usual way, a book of 196 pages has 4 full sheets and a fraction on one-twelfth 4,084 sheets and adding five per cent. brings the same result 4,288. The table saves the time of figuring and avoids possible mistakes.

COMPARATIVE WEIGHTS OF PAPERS

Equivalent Table

Showing Actual Weights of Standard Substances

Size	Weight—Per Ream							
25 x 38	40	45	50	60	70	80	100	120
28 x 42	50	56	62	74	86	99	124	
28 x 44	52	59	65	78	90	104	130	156
29 x 52	64		80	96	112	126	158	
30½ x 41	53		66	79	92	105	132	
32 x 44	60		74	89	104	119	148	
33 x 46	64	72	80	96	112	128	160	
38 x 50	80	90	100	120	140	160	200	240
41 x 61	106		132	158	184	210	262	
42 x 56	100	112	124	148	172	198	248	
44 x 64	120		148	178	208	238	296	

Table of 16 Page Folded Signature Sizes

Obtained from Standard paper sizes (before trimming)

(Allow 3/16" head, 3/16" front and 5/16" tail trim)

Sheet Size	Pages to One Side of Sheet						
	8	16	24	32	48	64	128
25 x 38	9½ x 12½	6¼ x 9½	6¼ x 6⅓	4¾ x 6¼	4¼ x 4¾	3⅓ x 4¾	2⅜ x 3⅓
28 x 36	9 x 14	7 x 9	6 x 7	4½ x 7	4½ x 4⅔	3½ x 4½	2¼ x 3½
28 x 40	10 x 14	7 x 10	6⅔ x 7	5 x 7	4½ x 5	3½ x 5	2½ x 3½
30 x 40	10 x 15	7½ x 10	6⅔ x 7½	5 x 7½	5 x 5	3¾ x 5	2½ x 3¾
30½ x 41	10¼ x 15¼	7⅝ x 10¼	6⁵/₆ x 7⅝	5⅛ x 7⅝	5³/₁₂ x 5⅛	3¹³/₁₆ x 5⅛	2⁹/₁₆ x 3¹³/₁₆
32 x 44	11 x 16	8 x 11	7⅓ x 8	5½ x 8	5¹/₃ x 5½	4 x 5½	2¾ x 4
33 x 46	11½ x 16½	8¼ x 11½	7⅔ x 8¼	5¾ x 8¼	5½ x 5⅔	4⅛ x 5¾	2⅞ x 4⅛
35 x 46	11½ x 17½	8¾ x 11½	7⅔ x 8¾	5¾ x 8¾	5⅔ x 5⁵/₆	4⅜ x 5¾	2⅞ x 4⅜
38 x 50	12½ x 19	9½ x 12½	8⅓ x 9½	6¼ x 9½	6¼ x 6⅓	4¾ x 6¼	3⅛ x 4¾
40 x 56	14 x 20	10 x 14	9⅓ x 10	7 x 10	6⅔ x 7	5 x 7	3½ x 5
41 x 61	15¼ x 20½	10¼ x 15¼	10⅙ x 10¼	7⁵/₆ x 10¼	6⁵/₆ x 7⁵/₆	5⅛ x 7⁵/₆	3¹³/₁₆ x 5⅛
42 x 62	15½ x 21	10½ x 15½	10⅓ x 10½	7¾ x 10½	7 x 7¾	5¼ x 7¾	3⅞ x 5¼

STANDARD BOARD SIZES IN BOOKBINDING

The old basis which extended from 32mo to quarto was understood to be:—

	32mo	3-1/8	x	4-5/8
	18mo	3-7/8	x	6-1/8
	16mo	4-1/4	x	6-7/8
	12mo	4-3/4	x	7-5/8
Crown	8vo	5-1/2	x	8-3/4
Regular	8vo	6	x	9-3/4
Royal	8vo	6-7/8	x	10-5/8
Imperial	8vo	7-1/2	x	11-5/8
Quarto	4to	8-1/4	x	12-5/8

In commercial usage and for governing piece-work labor prices, in practise these sizes are divided into six classes, namely:—

	12mo and under	4-3/4	x	7-5/8
Crown	8vo	5-1/2	x	8-3/4
Regular	8vo	6	x	9-3/4
Royal	8vo	6-7/8	x	10-5/8
Imperial	8vo	7-1/2	x	11-5/8
Quarto	4to	9	x	12-5/8

The divisional line is considered to be midway between these sizes. Consequently, the actual board sizes as divided in the six classes, are,

12 mo and under		up to and inc. 5-1/8 x 8-1/8	
Crown ...	8vo over 5-1/8 x 8-1/8	up to and inc. 5-3/4 x 9-1/4	
Regular .	8vo over 5-3/4 x 9-1/4	up to and inc. 6-3/8 x 10-1/8	
Royal ...	8vo over 6-3/8 x 10-1/8	up to and inc. 7-1/8 x 11-1/8	
Imperial .	8vo over 7-1/8 x 11-1/8	up to and inc. 8-1/4 x 12-1/8	
Quarto ..	4to over 8-1/4 x 12-1/8	up to and inc. 9	x 12-5/8

It is well to have these sizes in mind when planning a book, as the divisional dimensions show the points where important changes in the manufacturing costs occur.

ANNOUNCEMENT

In January, 1921, we shall be located in our new home, Metropolitan Building, Court Square, Long Island City, where our entire binding equipment will be operated on one large floor of 65,000 square feet, with 40,000 additional feet on ground floor and basement for receiving, shipping and storage of bound books.

With this increase to double our present space, our facilities for serving our clients will be greatly improved. The latest ideas in mechanical equipment, lighting, handling and routing of work are being adopted.

It is our hope that we may have the continued opportunity of serving publishers, printers and individual houses desiring a book manufacturing service of superior quality, maximum speed in production and an intelligent care of all details incident to the proper handling of a high grade product.

A cordial invitation is extended to everyone to visit us in our new home.

J. F. TAPLEY COMPANY

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